STAINLESS STEEL

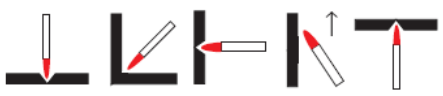
GLST-347 ELECTRODE

Classification : AWS A5.4 E347L-16
EN E 19 9 L R 32
ISO 3581 B-ES347-16

Characteristics and Application:

The main composition of **GLST-347L** is 19Cr-11Ni-Nb(Ti). The welding can be done in all position with AC/DC. Because adding Ti or Nb based on SUS308, the corrosion resistance can be improved, especially for intergranular corrosion resistance. It has excellent weld ability stable arc, nice molding, exquisite ripple, little spatter, good slag detachability; good fire and porosity resistance, stable, mechanical properties of deposited metal, high X-Ray eligibility rate. Be widely used in petrochemical, pressure vessel, food machinery, medical equipment, chemical fertilizers, and other related sectors, such as 1/0Cr18Ni9Ti(SUS321), 1/0Cr19Ni11Nb(SUS347).

Welding Postion :



Chemical Composition of Deposited Metal :

Element wt%	C	Mn	Si	Cr	Ni	Mo	P	S	Others
AWS	0.08	0.5-2.5	1.00	18.0-21.0	9.0-11.0	0.75	0.040	0.030	Cu0.75/Nb:8C-1.00
Type Value	0.04	1.45	0.74	19.44	9.39	0.49	0.013	0.013	Cu-.16/Nb0.44

Mechanical Property of Deposited Metal :

	Yield Stess MPa	Tensile Strength MPa	Elongation %	Charp V-notch J/℃
AWS	-	520	30	-
Typical	-	605	39	-

Notes on Usage:

1. Dry the stick electrodes at 300-350°C for one hour before welding. Do not dry them twice to avoid detachment of covering.
2. Be sure to remove moisture, oil and rust on the base metal.
3. Try to reduce heat input.
4. Choice of current: I= (25~40)*D; D means diameter of stick electrode.
5. Keep short arc length when welding to prevent the crack.
6. Control interpass(layer) temperature to make it under 100°C.
7. Remove the slag after each welding process.
8. When using AC, the stick electrode will become hot easily and there will be more spatter during welding process. The situation can be improved by using

Recommended Current Range

Diameter and Length/mm		2.0×350	2.6×350	3.2×350	4.0×350	5.0×350
Current/Amp	F	30-55	50-85	80-120	100-150	140-180
	V, OH	20-50	45-80	70-110	90-135	-