



# Tech-Rod 347

## Description

Tech-Rod 347 electrodes are niobium stabilized stainless steel electrodes used for the welding of types 347 and 321 stainless and stainless clad steels. The niobium content is approximately ten times the carbon content and when this product is used to weld stabilized type 347 and 321 parent metals, it reduces inter-granular corrosion under severe operation conditions.

## Specifications & Approvals

AWS A5.4 E347-16

UNS W34710

ISO 3581:2003 (19 9 Nb)

CWB

ASME QSC-395

## Typical Chemical Composition

C	Mn	Si	Fe	Cr	Mo	Ni	Nb	N	S	P	Cu	FN
.05	1.64	.52	BAL	19.15		10.15	.6	*	.017	.024		7

\* Nitrogen in these weld deposits is usually between .04% and .08%

## Typical Mechanical Properties

Tensile Strength	86,000 PSI	590 MPA
Yield Strength	57,000 PSI	390 MPA
Elongation	35%	

## Welding Parameters

Process	Diameter x Length	Voltage	Amperage	
			Flat	Vertical & Overhead
SMAW	3/32" (2.4mm) x 12" (305mm)	24-28	70-85	65-75
	1/8" (3.2mm) x 14" (355mm)	26-30	85-110	80-90
	5/32" (4.0mm) x 14" (355mm)	28-32	110-140	100-120
	3/16" (4.8mm) x 14" (355mm)	28-32	120-160	110-130

## Standard Packages:

3/32" Diameter	8 Lb (3.6Kg) Can	24 Lb (10.9Kg) Master Carton	26 Electrodes per Lb
1/8" Diameter	10 Lb (4.5Kg) Can	30 Lb (13.6Kg) Master Carton	14 Electrodes per Lb
5/32" Diameter	10 Lb (4.5Kg) Can	30 Lb (13.6Kg) Master Carton	9 Electrodes per Lb
3/16" Diameter	10 Lb (4.5Kg) Can	30 Lb (13.6Kg) Master Carton	6 Electrodes per Lb