

# NC-347

For welding of 18%Cr-8%Ni-Nb stainless steel

AWS A5.4 E347-16  
KS D 7014 E347-16  
JIS Z3221 ES347-16

## Applications

Welding of AISI (SUS) 304L, 321, 347 stainless steel.

## Characteristics

NC-347 is a lime-titania type electrode for all-position welding, which has excellent usability.

As its weld metal has austenitic structure containing Nb, its intergranular corrosion resistibility is good and its creep rupture strength is also excellent.

## Notes on usage

- (1) Keep the arc as short as possible.
- (2) Weaving width should be within two and a half times of electrode's diameter.
- (3) When the electrodes have absorbed moisture, dry them at 250~300°C for 60~90 minutes before use.
- (4) Usually, preheat is not necessary.

## Typical chemical composition of weld metal (%)

C	Mn	Si	P	S	Cr	Ni	Nb+Ta
0.035	1.05	0.78	0.021	0.010	19.5	9.66	0.45

## Typical mechanical properties of weld metal

TS N/mm <sup>2</sup> (kgf/mm <sup>2</sup> )	EL %
650(66)	37

## Typical corrosion resistance of weld metal

40% HNO <sub>3</sub> (Nitric acid) Boiling	0.098g/m <sup>2</sup> · hr
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## Size & recommended current range (AC or DC +)

Dia. (mm)	2.6	3.2	4.0	5.0	
	L (mm)	300	350	350	350
Amp.	F	50-80	80-120	100-150	140-190
	V&OH	45-70	70-100	95-140	-

• Approval : ABS

• Tip Color :Blue