RNY347HT

● Applicable Specification

JIS Z 3221 ES347-16
AWS A5.4 E347-16

● Identification Color

End Face: Blue
Side Face: White

● Applications and Characteristics

TASETO RNY347HT is the electrode developed with the objective of keeping the ferrite content in its all weld metal at 3% to 7% and improving the performance (resistance to creep rupture) in elevated temperatures. It is used for welding of Type 347 stainless steel.
RNY347HT is a lime-titania type electrode suitable for all position welding.

● Notes on Usage

* Dry the electrode at 150℃ to 200℃ for 60 minutes before use.
* Remove oil and dust from the surface to be welded.
* Use welding current as low as possible to reduce intergranular corrosion.

● Chemical Composition of All Weld Metal (%)

	C	Si	Mn	P	S	Ni	Cr	Mo	Cu	Nb
Typical	0.056	0.48	1.72	0.028	0.002	9.87	19.21	0.08	0.05	0.61

● Mechanical Properties of All Weld Metal

	0.2% Proof Stress (MPa)	Tensile Strength (MPa)	5D Elongation (%)
Typical	508	612	40.2

● Typical Mechanical Properties of All Weld Metal at High Temperatures

Temperature (℃)	0.2% Proof Stress (MPa)	Tensile Strength (MPa)	5D Elongation (%)
550	340	425	18.6
650	311	395	18.2
700	304	357	18.8

● Typical Creep Rupture Strength at High Temperatures

550℃×1,000h：232 MPa
650℃×1,000h：179 MPa

● Other Properties of All Weld Metal

* Typical Ferrite Content：5.3% (Schaeffler's Diagram)

● Sizes Available, Recommended Currents (AC or DCEP)

Size (mm)	Length (mm)	Welding Current (A)	
		Flat	Vertical, Overhead
2.6	300	50～90	45～80
3.2	350	80～120	65～110
4.0	350	110～150	85～135
5.0	350	150～200	－