

# TASETO Welding Materials

Stainless Steel Electrodes

For Shielded Metal Arc Welding

## RNY347

### ● Applicable Specification

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

### ● Identification Color

End Face: Blue  
Side Face: —

### ● Applications and Characteristics

Since TASETO RNY347 has excellent resistibility to intergranular corrosion in polythionic acid conditions of desulfurization plant, because of carbon stabilizing effect of Nb added in weld metal. It is used for welding of Type 347 and Type 321 stabilized stainless steel.

RNY347 is a lime-titania type electrode suitable for all position welding.

### ● Notes on Usage

\* Dry the electrode at 150°C to 200°C for 60 minutes before use.

\* Since Nb is added, crack sensitivity is high. Thus avoid excessively high current or excessively rapid weaving.

### ● Chemical Composition of All Weld Metal (%)

	C	Si	Mn	P	S	Ni	Cr	Mo	Cu	Nb
Typical	0.042	0.52	1.57	0.023	0.005	9.63	19.22	0.07	0.06	0.70

### ● Mechanical Properties of All Weld Metal

	Tensile Strength (MPa)	5D Elongation (%)
Typical	600	41.0

### ● Other Properties of All Weld Metal

\* Typical Ferrite Content : 8.2% (Schaeffler's Diagram)

\* 65% Nitric Acid Test : max. 0.001 in/month

max. 0.0025 in/month (650°C × 2h, AC)

\* Copper Sulfate-Sulfuric Acid Test : No defects after bend (650°C × 2h PWHT)

### ● 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	—