

TASETO Welding Materials

Stainless Steel Electrodes

For Shielded Metal Arc Welding

RNY347L

● Applicable Specification

JIS Z 3221 ES347L-16
AWS A5.4 E347-16

● Identification Color

End Face: Blue
Side Face: Blue

● Applications and Characteristics

TASETO RNY347L has the same uses as RNY347. As it contains less carbon than RNY347, the resistibility to intergranular corrosion is better than RNY347. RNY347L is suitable for overlay welding of Type 347 stainless steel.

● Notes on Usage

- * Dry the electrode at 150°C to 200°C for 60 minutes before use.
- * Since Nb is added, hot cracking 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	0.031	0.45	1.59	0.020	0.004	9.72	19.30	0.08	0.06	0.50

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Typical	0.031	0.45	1.59	0.020	0.004	9.72	19.30	0.50

● Mechanical Properties of All Weld Metal

	Tensile Strength (MPa)	5D Elongation (%)
Typical	584	40.8

● Other Properties of All Weld Metal

- * Typical Ferrite Content :8.5% (Schaeffler's Diagram)
- * 65% Nitric Acid Test : max. 0.001 in/month
- * 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	—