DURAMAX®
Inspiring the future generations of welders

Product
Data Sheet

DURA MAX E347-16 - DM347-16 FLUX COATED STAINLESS STEEL ELECTRODE

Classification: AWS A5.4 / ASME SFA 5.4

Typical Application

A low carbon, 19Cr-10Ni-Cb stainless steel electrode depositing stabilized weld metal. Weld metal offers excellent resistance to intergranular corrosion. Electrode gives smooth arc, easy slag detachability and is almost spatter free with fine finish weld deposit.

Characteristics on Usage

1) Ideally suitable for welding stainless steel conforming to AISI 304, 304L, 321, 347.
2) And their equivalents used in fertilizer, petrochemical, chemical and pharmaceutical industries.

Flux Color: White - Grey

Typical Chemical Composition (%)

C	Cr	Ni	Mo	Mn	Si	P	S	Cu	Nb
0.08 max	18.0-21.0	9.0-21.0	0.75 max	0.5-2.5	1.00 max	0.04 max	0.03 max	0.75 max	8 X C min to 1.00 max

Typical Mechanical Properties as Welded

Tensile Strength (n/mm^2)	Yield Strength (n/mm^2)	Elongation (%)	Hardness	Ferrite WRC (FN)	CVN Impacts (J) @ +20 °C
590 n/mm^2	420 n/mm2	42%	-------	4-10 FN	60 - 80 J

Microstructure: Austenite with 4 - 10% ferrite. Typical ferrite number is 6.

Sizes available and recommended currents (DC +) or (AC)

Amps for Positions / Diameters	**5/64**	**3/32**	**1/8**	**5/32**	**3/16**
F/H-Fillet	35–55	50–85	80–120	100–150	140–200
V-up/OH	30–50	45–85	70–110	90–135	----

RE-DRY CONDITION: Re-Dry the electrode at 250°C for 1 hrs before use.

POLARITY: DCEP or AC
DCEP = DC, Electrode Positive (reverse polarity) has the most weld penetration.
AC: medium weld penetration (can be more spatter)
USE LESS AMPS ON THIN METAL; MORE AMPS ON THICK METALS
WELDING POSITIONS: Flat, Horizontal, Vertical-up and Overhead positions

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