WELDWIRE COMPANY, INC. **Technical Information**

Stainless Steel Electrodes

Alloy: WW347-16 Class: E347-16

Conforms to Certification: AWS A5.4 ASME SFA A5.4

Alloy: E347-16

Weld Process: Shielded Manual Metal Arc

AWS Chemical Composition Requirements

C = 0.08 max	Si = 1.0 max
Cr = 18.0 – 21.0	P = 0.04 max
Ni = 9.0 – 11.0	S = 0.03 max
Mo = 0.75 max	Cu = 0.75 max
Mn = 0.5 – 2.5	

Nb (Cb) + Ta = 8 x C min – 1.00 max

Deposited All Weld Metal Properties %
(Typical) As-Welded

Yield Strength	86,500psi
Tensile Strength	58,000psi
Elongation	34.5%

Deposited Chemical Composition % (Typical)

C = 0.05	Si = 0.52
Cr = 19.15	P = 0.021
Ni = 10.10	S = 0.019
Mn = 1.65	Nb = 0.44

Deposited Charpy-V-Notch Impact Properties %

Not Applicable

Recommended Welding Parameters

Diameter	Voltage	Amperage Flat Position	Amperage Vertical & Overhead
3/32	24-28	70-85	65-75
1/8	26-30	85-110	80-90
5/32	28-32	110-140	100-120
3/16	28-32	120-160	110-130

Application

E347-16 is designed for welding AISI 347 and AISI 321 alloys. The columbium content acts as a stabilizer and prevents carbide precipitation.

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If additional information is needed Contact Weldwire Company, Inc. 800-523-1266