



EI 347

Coated Electrode for Stainless Steels -

Standards	
AWS/ASME SFA - 5.4	E347-16
EN ISO 3581 - A	E 19 9 Nb R 32
TS EN ISO 3581 - A	E 19 9 Nb R 32
Properties and Applications	
Rutile type stainless steel electrode for welding stabilized austenitic stainless Cr-Ni steels, and cast steels, as well as stainless or heat resisting chromium steels to cast steels. Stabilized with Nb (Niobium) and resistant to intergranular corrosion. Weld metal is suitable for operating temperatures up to +400°C, non-scaling up to +800°C. Especially suitable for welding of stainless steel tanks, valves and pipes in milk, beverage, food, chemical and petrochemical industries. Possible to use equally well both with AC and DC. Easy arc striking and re-striking. Fine metal droplet transfer, good fusion of joint faces, finely rippled bead surface, easily removable slag.	

Approvals & Certificates		
TSE	TUV	CE
Materials		
EN	Material	ASTM
X5CrNi18-10	1.4301	304
X4CrNi18-12	1.4303	305
X2CrNi19-11	1.4306	304L
GX5CrNi19 10	1.4308	CF-8
X6CrNiTi18-10	1.4541	321
X6CrNiNb18-10	1.4550	347, 347H
GX5CrNiNb19-11	1.4552	
X8CrNiTi18-10	1.4878	321H

Typical Chemical Values of Weld Metal						
Type of Analysis	C	Si	Mn	Cr	Ni	Nb
Weld Deposit	0.02	0.70	0.90	19.70	10.30	0.30
Typical Mechanical Values of Weld Metal						
Test Condition	Tensile Strength (N/mm ²)		Elongation A5 (%)		Charpy V-Notch Properties (J)	
As welded	600		38		20°C → 70	

Application Information	
Welding Positions       PA PB PC PD PE PF	Polarity:  
Welding Parameters & Efficiency	
Diameter x Length (mm)	Current (A)
2.00x250	35-50
2.00x300	35-50
2.50x250	50-80
2.50x300	50-80
3.25x300	80-120
3.25x350	80-120
4.00x350	110-160
5.00x350	140-220

Packaging Information						
Product Code	Diameter x Length (mm)	Quantity per Box	Box Gross Weight (Kg)	Boxes per Outer Box	Outer Box Gross Weight (Kg)	Packaging Type
13022CIEM1	2.00x250	125 AD	1.30	9	11.90	VAC Box
13022DDEM1	2.00x300	210 AD	2.60	3	7.90	Plastic Box
13022DIEM1	2.00x300	125 AD	1.54	9	14.10	VAC Box

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13022GDEM1	2.50x300	130 AD	2.60	3	7.90	Plastic Box
13022GDEM2	2.50x300	134 AD	2.62	3	8.00	Plastic Box
13022GIEM1	2.50x300	80 AD	1.55	9	14.20	VAC Box
13022GJEM2	2.50x300	94 AD	1.79	9	16.30	VAC Box
13022MJEM1	3.25x300	60 AD	1.88	9	17.10	VAC Box
13022MJEM2	3.25x300	58 AD	1.79	9	16.30	VAC Box
13022NDEM1	3.25x350	70 AD	2.60	3	8.00	Plastic Box
13022NDEM2	3.25x350	71 AD	2.70	3	8.10	Plastic Box
13022NJEM1	3.25x350	60 AD	2.21	9	20.10	VAC Box
13022NJEM2	3.25x350	56 AD	2.04	9	18.60	VAC Box
13022QJEM1	4.00x350	40 AD	2.12	9	19.30	VAC Box
13022QJEM2	4.00x350	39 AD	2.04	9	18.60	VAC Box
13022TJEM1	5.00x350	30 AD	2.54	9	23.10	VAC Box
13022TJEM2	5.00x350	24 AD	2.04	9	18.60	VAC Box

Storage & Re-Drying Information

It can be dried maximum 5 times.
It should be stored in a dry room (relative humidity < 50%, room temperature > 20°C) on wooden pallets.
It has to be dried at 350°C for 2 hours.



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