

# TS-347H

AWS A5.4 E347-16  
EN ISO 3581-B-ES347-16  
JIS Z 3221 ES347-16

## Characteristics and Applications:

TS-347H is an electrode for the use of high temperature CrNi austenitic steel for service temperatures exceeding +400 °C. Specially designed for the base metal AISI 347H or 321H. Controlled ferrite content of 3-8 FN. The deposit is less susceptible to embrittlement and is scaling resistant.

## Notes on usage:

1. Clean up the contaminations on the base metal, groove and pass to pass with stainless steel brush.
2. Maintain short arc length. Moving range should be controlled within 2.5 times of the wire's dia when you are welding with weave method.
3. Dry the electrodes at 250~300°C for 60 minutes before using. Take out consumables for half day consumption and keep in the environment at 100~150°C during welding process.
4. Use lower current to prevent from crack and minimize base metal dilution.

## Typical chemical composition of weld metal (wt%):

C	Mn	Si	P	S	Cr	Ni	Nb
0.06	1.30	0.50	0.035	0.010	20.00	9.50	8xC ~ 1.0

## Typical mechanical properties of weld metal:

Tensile strength MPa(ksi)	Elongation %
630(91)	36

## Welding position:



## Sizes and recommended current range (AC or DC <+>):

Diameter (mm)	2.6	3.2	4.0	4.8	
Length (mm)	300	350	350	350	
Amps	F	60-90	80-130	130-170	180-210
	V&OH	50-70	70-110	100-130	-

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