

## Stick electrode

**Features:** ▪ Suitable for 18%Cr-8%Ni-Nb steel

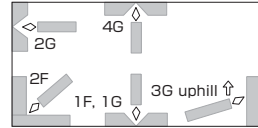
**Classification:** AWS A5.4 E347-16

**Redrying Conditions:** 150~200°Cx0.5~1h

**Identification color:** 1st Blue, 2nd Blue

**Polarity:** AC, DCEP

## Welding Positions:



## Packaging data

φ mm	Length mm	kg/pack	kg/carton	g/piece	carton mm
2.6	250	2	20	15	300W, 100H, 280L
3.2	300	2	20	28	300W, 95H, 330L
4.0	350	5	20	50	175W, 120H, 380L
5.0	350	5	20	77	175W, 120H, 380L

## Composition (all-weld metal mass%)

	Typical (AC)	Guaranty <sup>a</sup>
<b>C</b>	0.06	0.08
<b>Si</b>	0.55	1.00
<b>Mn</b>	1.5	0.5~2.5
<b>P</b>	0.02	0.04
<b>S</b>	<0.01	0.03
<b>Ni</b>	10.1	9.0~11.0
<b>Cr</b>	19.6	18.0~21.0
<b>Mo</b>	0.04	0.75
<b>Cu</b>	0.04	0.75
<b>Nb+Ta</b>	0.67	8xC%~1.00

Note: <sup>a</sup>Single values are maximum.

## Welding parameters (A)

φ mm	1F, 1G, 2F, 2G	3G uphill, 4G
2.6	50~85	45~80
3.2	70~115	65~110
4.0	95~145	85~135
5.0	135~180	-

## All-weld mechanical properties

	Typical (AC)	Guaranty
<b>0.2%YS (MPa)</b>	470	-
<b>TS (MPa)</b>	670	518min.
<b>El on 4d (%)</b>	34	30min.