

TECH-ROD 347

- I. **DESCRIPTION:** Tech-Rod 347 electrodes are columbium stabilized stainless steel electrodes used for the welding of Types 347 and 321 stainless and stainless clad steels. The columbium content is approximately ten times the carbon content, and when this product is used to weld stabilized Type 347 and 321 parent metal, it precludes intergranular corrosion under severe operating conditions.
- II. **APPROVALS:** Manufactured under Quality System approved by ASME, ISO9001. Meets AWS 5.4 Class E347-16.

III. **CHEMICAL COMPOSITION**

Carbon	.55
Manganese	1.65
Silicon	.52
Chromium	19.15
Nickel	10.15
Columbium	.75
Sulfur	.017
Phosphorus	.024
Iron	Balance

MECHANICAL PROPERTIES

Tensile Strength	
86,000 PSI	590 MPA
Yield Strength	
57,000 PSI	390 MPA
Elongation	35%

IV. **WELDING PARAMETERS**

Direct Current
Electrode + Ve

AMPERAGES:

3/32"	65-75
1/8"	90-105
5/32"	120-135
3/16"	135-155

(For vertical welding amperages are to be reduced by 10 to 15 amps)

V. **PACKAGES AVAILABLE:**

3/16"-10# can, 5/32"-10# can, 1/8"-10# Can, 3/32"-8# can