TOKO®

TOKO TECHNOLOGY (WUXI) CO.,LTD

MILL TEST CERTRIFICATE

TOKO E347-16 welding rod is type of covering: Lime-titania, used for welding structures made by category of Cr18Ni11 stainless steels which contain titanium or stabilizing agent niobium, e.g. 06Cr18Ni11Ti, 06Cr18Ni11Nb. The weld metal has good mechanical properties and good resistance to inter-crystalline corrosion. Its coating flux is not easy to be red when welding.

E347-16 Chemical Composition of Deposited Metal (%)

	C	MN	SI	P	S	NI	CR	MO	CU	NB+TA
Standard	≤0.08	0.5-2.5	≤1.00	≤0.04	≤0.03	9.0-11.0	18.0-21.0	≤0.75	≤0.75	8 x C-1.00
Typical	0.042	0.95	0.86	0.027	0.012	9.50	19.95	0.035	0.020	0.56

Mechanical Properties of Deposited Metal (AW)

	TENSILE STRENGTH RM (MPA)	ELONGATION A4 (%)
Standard	≥520	≥25
Typical	650	38

Sizes & Recommended Current (DC+)

E347-16 WELDING ROD DIAMETER	2.0MM	2.5MM	3.2MM	4.0MM	5.0MM
Welding Rod Length (mm)	300	300	350	350	350
F, H Welding Current (A)	30-50	50-85	85-120	120-160	150-200
V, OH Welding Current (A)	30-50	50-70	70-100	90-135	

Welding Position: F, H, HF, OH, V
Type of Current: DCEP or AC
Notice: Welding rods should be baked at 300℃-350℃ for 1 hour before use.
The surfaces to be welded must be cleaned away impurities of oil contamination, moisture and so on.
Smaller current and short arc are recommended in welding and weave beads no wider than 2.5 times of the diameter of the core rod is better.