

TOKO TECHNOLOGY (WUXI) CO.,LTD

MILL TEST CERTIFICATE

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°C-350°C 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.



The information contained or otherwise referenced herein is presented only as "typical" without guarantee or warranty, and TOKO Corporation expressly disclaims any liability incurred from any reliance thereon. Typical data and Test results for mechanical properties, deposit or electrode composition and other properties were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application.