

# Jungo® 347

## CLASSIFICATION

AWS A5.4 : E347-15  
ISO 3581-A : E 19 9 Nb B 22

## TEMPERATURE RANGE

Pressurized parts :-120...+400°C  
Oxidation resistance :to 800°C

## GENERAL DESCRIPTION

Basic coated all position stainless steel electrode  
For Ti or Nb stabilized 304 or equivalent steels [AISI 321 and 347]  
High resistance to intergranular corrosion  
Easy slag release and smooth bead appearance  
Strong electrode coating

## WELDING POSITIONS (ISO/ASME)



PA/1G



PB/2F



PC/2G



PF/3Gu



PE/4G



PH/5Gu

## CURRENT TYPE

DC +

## APPROVALS

TÜV

+

## CHEMICAL COMPOSITION (W%), TYPICAL, ALL WELD METAL

C	Mn	Si	Cr	Ni	Nb	FN (acc.WRC 1992)
0.02	1.6	0.5	20.0	10.0	0.40	6-12

## MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

Condition	0.2% Proof strength [N/mm <sup>2</sup> ]	Tensile strength [N/mm <sup>2</sup> ]	Elongation [%]	Impact ISO-V(J)		
				+20°C	-20°C	-120°C
Required: AWS A5.4 ISO 3581-A Typical values	not required min. 350 500	min. 520 min. 550 630	min. 30 min. 25 35	not required not required 80	50	40
AW						

## PACKAGING AND AVAILABLE SIZES

Unit: Carton + PE foil	Diameter (mm)	2.5	3.2	4.0
	Length (mm)	350	350	350
Pieces / unit	150	100	75	
Net weight/unit (kg)	2.6	4.8	4.4	

Identification Imprint: 347-15 / JUNGO 347

Tip Color: brown

Jungo®347:rev.C-ENZ7-01/02/15

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## EXAMPLES OF MATERIALS TO BE WELDED

Steel grades	EN 10088-1/-2	EN 10213-4	Mat. Nr	ASTM/ACI A240/A312/A351	UNS
<b>Ti-, Nb stabilized</b>					
	X6CrNiTi18-10		1.4541	(TP)321 (TP)321H	S32100 S32109
	X6CrNiNb18-10		1.4550	(TP)347 (TP)347H	S34700 S34709
		GX5CrNiNb19-10	1.4552	CF-8C 302	J92710
<b>Non stabilized</b>					
	X4CrNi18-10		1.4301	(TP)304	S30400
	X2CrNi19-11		1.4306	(TP)304L	S30403
		GX5CrNi19-10	1.4308 1.4312	CF-8 (TP)304H	J92600 S30409

## CALCULATION DATA

Sizes		Current range (A)	Current type	Arc time	Energy	Dep. rate	Weight/ 1000 pcs (kg)	Electrodes/ kg weldmetal B	kg electrodes/ kg weldmetal 1/N
Diam. x length (mm)	- per electrode at max. current - (S)*			E(kJ)	H(kg/h)				
3.2 x 350	80 - 100	DC+	51	135	1.3	32.4	53	1.72	
4.0 x 350	100 - 130	DC+	66	206	1.7	44.4	32	1.56	
5.0 x 450	130 - 160	DC+	69	378	2.3	90.9	23	1.92	

\*Stub end 35mm

## WELDING PARAMETERS, OPTIMUM FILL PASSES

Diameter (mm)	Welding positions					
	PA/1G	PB/2F	PC/2G	PF/3Gup	PE/4G	PH/5Gup
3.2	95A	90A	90A	75A	75A	75A
4.0	125A	110A	125A	100A	100A	100A
5.0	150A	150A				