THE HARRIS PRODUCTS GROUP
A LINCOLN ELECTRIC COMPANY
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TECHNICAL SPECIFICATION SHEET

347-16 STAINLESS STEEL COVERED ELECTRODE

NOMINAL COMPOSITION:

Carbon	.08% max.	Chromium	18.0-21.0%
Nickel	9.0-11.0%	Manganese	.5-2.5 %
Copper	.75% max.	Silicon	.90% max.
Phosphorus	.04% max.	Sulfur	.03% max.
Molybdenum	.75% max.	Iron	Balance
Columbium/Tantalum	8 X C min.-1.0 max.	Normal Ferrite Range	4-10

TYPICAL MECHANICAL PROPERTIES AS WELDED:

Yield Strength (psi)	64,000	Elongation	36%
Tensile Strength (psi)	96,000		

WELDING PROPERTIES:

The nominal composition of this weld metals is 19% Chromium and 10% Nickel with columbium preventing carbide precipitation making it more corrosion resistance than 308. Used on base metals such as 347 and 321 also used weld metal subjected to temperatures above 700 f .

347-16 is a titania type coating for either alternating current (AC) or direct current (DC) reverse polarity.
347-15 is a lime type coating for use with direct current (DC) reverse polarity.

RECOMMENDED WELDING PARAMETERS:

	3/32 X 12	1/8 X 14	5/32 X 14
AMPS	50-80	70-110	100-140

All parameters are suggested as basic guidelines and will vary depending on joint design, number of passes and other factors.

SPECIFICATION COMPLIANCE: ANSI/AWS A5.4 & ASME SFA 5.4 E 347-16

5/99 DC

WARNING: PROTECT yourself and others. Read and understand this information.
FUMES AND GASES can be hazardous to your health.
ARC RAYS can injure eyes and burn skin.
ELECTRIC SHOCK can KILL.

- Before use, read and understand the manufacturer's instructions, Material Safety Data Sheets (MSDSs), and your employer's safety practices.
- Keep your head out of fumes.
- Use enough ventilation, exhaust at the arc, or both, to keep fumes and gases from your breathing zone and the general area.
- Wear correct eye, ear, and body protection.
- Do not touch live electrical parts.
- See American National Standard Z49.1, *Safety in Welding, Cutting, and Allied Processes,* published by the American Welding Society, 550 N.W. LeJeune Road, Miami, Florida 33126; OSHA Safety and Health Standards, available from the U.S. Government Office, Washington, DC 20402

Additional information available at our web site: *www.harrisproductsgroup.com*
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