



# LKE-347-16

LINKWELD ALLOYS INC.

AWS	A5.4 E347-16
EN	EN1600 E 19 9 Nb R 1 2
JIS	Z3221 D347-16

### Characteristics:

LKT-347 is a niobium-bearing rutile electrode for Ti and Nb stabilized 18Cr-8Ni steels. Good intergranular corrosion resistance and heat resistance can be obtained due to its Nb content. It is used for AISI 347, 321, 304L steels.

### Applications:

It is suitable for welding of stainless steel piping, boiler and gas turbine.

### Notes on Usage:

1. Dry the electrodes at 200-250°C for 60 minutes and keep at 100-150°C before use.
2. Use lower currents and keep the arc as short as possible.

### Typical chemical composition of weld metal (wt%)

C	Mn	Si	P	S	Cr	Ni	Nb
0.04	1.30	0.60	0.020	0.015	19.50	9.10	0.60

### Typical mechanical properties of weld metal

TS N/mm <sup>2</sup>	EL %
600	37

### Welding position:



### Sizes and recommended current range (AC or DC <+> )

Diameter (mm)		2.0	2.6	3.2	4.0	5.0
Length (mm)		250	300	350	350	350
Amps	F	30-55	50-85	80-120	100-150	140-180
	V&OH	20-50	45-80	70-110	90-135	-
Weight per pack(kg)		4/5	4/5	5	5	5
Weight per carton (kg)		20	20	20	20	20