

AK E347-16

Description: Basic coated electrode designed for high quality welding. Excellent strength and toughness properties. It is also suitable for welding steels with low purity and high carbon content.

Application: For welding of steel structures, boiler and vessel construction, vehicle construction, shipbuilding and machinery construction and buffer layer when constructed on high carbon steel.

Typical Chemical Composition(%):

	C	Si	Mn	S	P	Ni	Mo	Cr	Cu
Requirement	0.08	1.00	0.5-2.5	0.03	0.03	9.0- 11.0	0.75	18.0-21.0	0.75
Actual Result	0.051	0.68	0.85	0.003	0.025	9.6	0.12	19.80	0.10

Typical Mechanical Properties:

	Tensile strength (MPa)	Yield Stress (MPa)	Elongation (%)	Impact Values (J)
Requirement	≥ 520		≥25	
Actual Result	610		40	

Recommended welding parameters:

Diameter/mm		2.5	3.2	4.0
Welding current/A	F/H	60-80	80-120	100-150
	V/ OH	40-70	60-100	80-130