

Product Data Sheet



BRAND NAME VJ 347

AWS/ASME Class E347 -16

SPECIFICATION SFA A5.4

Features and Applications :

VJ 347 is a Nb-stabilized 19Cr-10Ni rutile electrode, offering excellent performance in AC/DC (+) welding. It prevents intergranular cracking (425°C-850°C) and provides smooth, easy-to-remove slag with superior radiographic quality. Ideal for welding ASTM/ASME 321, 347, 304, and 304L stainless steels, it's widely used in industries like food, chemical, petrochemical, and aerospace.

CHEMICAL COMPOSITION :

All Weld Metal (%)			
TYPICAL	Max	TYPICAL	Max
C	0.08	Mn	0.50-2.50
Cr	18.0-21.0	Si	1.00
Ni	9.0-11.0	S	0.03
Mo	0.75	P	0.04
Cu	0.75	Cb	1.00

MECHANICAL PROPERTIES OF WELD METAL

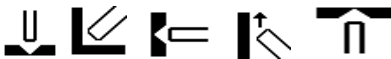
All Weld Metal - As Welded	
Properties	Typical
UTS (MPa)	520 Min
El (%)	30 Min

DIMENSIONS & CURRENT DATA

Dimension (mm)	Current (A)		Packing (Pcs)
Dia x Length	Min	Max	Qty / Pkt
2.50 x 350	50	80	150
3.15 x 350	80	130	100
4.00 x 350	130	170	75
5.00 x 350	170	220	50

CURRENT : AC/DC (+)

WELDING POSITION:



OTHER DATA:

Redrying: The electrodes should be redried at 250°C for 1 hour.