



Unibraze 347-16

CLASSIFICATIONS: AWS A5.4/ASME SFA 5.4 Class E347-16

UNS S34710

ISO 3581:2003 (19 9 Nb)

DESCRIPTION: Unibraze 347-16 is a niobium stabilized stainless steel electrode used to weld Types 321 and 347. The addition of niobium reduces the possibility of inter-granular corrosion under severe operating conditions.

TYPICAL CHEMISTRY:

C	Cr	Ni	Mo	Mn	Si	P	S	Cu	Nb + Ta	FN (WRC)
0.08 max	18.0-21.0	9.0-11.0	.75 max	0.5-2.5	1.0 max	0.04 max	0.03 max	0.75 max	8xC% - 1.0	7

TYPICAL MECHANICAL PROPERTIES:

Tensile Strength	86,000 psi (590 MPa)
Yield Strength	57,000 psi (390 MPa)
Elongation	35%

TYPICAL WELDING PARAMETERS:

	Diameter	Voltage	Amperage	
			Flat	Vertical/Overhead
SMAW	3/32" (2.4mm)	24-28	70-85	65-75
	1/8" (3.2mm)	26-30	85-110	80-90
	5/32" (4.0mm)	28-32	110-140	100-120
	3/16" (4.8mm)	28-32	120-160	110-130

Notice: The results reported are based upon testing of the product under controlled laboratory conditions in accordance with American Welding Society Standards. Actual use of the product may produce different results due to varying conditions. An example of such conditions would be electrode size, plate chemistry, environment, weldment design, fabrication methods, welding procedure and service requirements. Thus the results are not guarantees for use in the field. The manufacturer disclaims any warranty of merchantability or fitness for any particular purpose with respect to its products.