



Manufacturers of Custom Welding Lines for Resale
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SELECTRODE
1134
347-16

INTERNATINOAL CLASSIFICATIONS

AWS/ASME A 5.4 E 347-16

EN 1600: E 19 9 Nb R 32

DIN 8556: E 19.9 Nb R 26

ISO 3581: E 19.9 Nb R 32

NFA 81-343: EZ 19.9 Nb R 26

BS 2926: 1984 19.9 Nb R

FEATURES & APPLICATIONS

General joining use in the food and beverage industry. Also for architectural applications.

Stainless steel electrode designed specifically for welding titanium and niobium stabilized 18/8 stainless steels

- Excellent out of position weldability.
- High purity core wire yields extremely low carbon content.
- Controlled silicon content for maximum cracking/corrosion resistance.

ALL WELD METAL ANALYSIS (TYPICAL WEIGHT %)

Microstructure: Austenite with 7-9% ferrite. Typical ferrite number is 6.

Flux Color: White/Grey

c	Mn	Si	S	P	Cr	Ni	Mo	Nb	Cu	Fe
.02	.7	1.0	.01	.02	19	10	.5	.9	.07	bal

TYPICAL MECHANICAL PROPERTIES

Undiluted Weld Metal

Maximum Value Up to:

Tensile Strength	82,000 PSI (560 MPa)
Yield Strength	57,000 PSI (370 MPa)
Elongation	35%
Impact Energy	70J: 68°F (20°C), 20J: -320°F (-196°C)
Hardness	Brinell 205, Rockwell B94

WELDING CURRENT & INSTRUCTIONS

Recommended Current: DC Reverse (+) or AC

Diameter (mm)	3/32 (2.5)	1/8 (3.25)	5/32 (4.0)
Minimum Amperage	55	75	90
Maximum Amperage	75	110	140

Welding Techniques: Material to be welded should be clean of all contaminants. Maintain a short arc and use stringer beads rather than a weave technique.

Welding Positions: Flat, Horizontal, Vertical up, Overhead

Deposition Rates:

Diameter (mm)	Length (mm)	Weldmetal/ Electrode	Electrodes per lb (kg) of Weldmetal	Arc Time of Deposition min/ lb (kg)	Amperage Settings	Recovery Rate
3/32 (2.5)	12" (300)	.3 oz (9g)	50 (109)	35 (76)	65	100%
1/8 (3.25)	14" (350)	.7 oz (20g)	22 (49)	21 (46)	95	100%
5/32 (4.0)	14" (350)	1 oz (29g)	15 (33)	18 (40)	120	100%

APPROXIMATE ELECTRODE PACKAGING & DIMENSIONS

Diameter (mm)	3/32 (2.5)	1/8 (3.25)	5/32 (4.0)
Length (mm)	12" (300)	14" (350)	14" (350)
Electrodes / lb	28	13	9
Electrodes / kg	62	29	20