



# FCT 347

*TIG cored wire  
for root pass on 347/321*

## Classification

AWS A5.22 : R347T1-5

## Description & Applications

Flux cored wire for TIG welding for 347 or 321 stainless steel. This product is dedicated to the root pass. Indeed this slag protects the reverse side from the oxidation by the atmosphere. Used for application with service temperature between 0°C and +350°C.

**Main applications:** Root pass for steel piping, petro chemical

### Base materials:

UNS	Grade	EN 10088	N° Mat.
S30400	304	X5CrNi18-10	1.4301
S30403	304L	X2CrNi19-11	1.4306
S32100	321	X6CrNiTi18-10	1.4541
S34700	347	X6CrNiNb18-10	1.4550

## Typical Chemical Composition ( % )

	C	Si	Mn	Cr	Ni	Mo	Cu	Nb	P	S
Min			0.5	18.0	9.0			8 x C		
Max	0.08	1.2	2.5	21.0	11.0	0.75	0.75	1.0	0.04	0.03
Type	0.04	0.80	1.5	19.5	10.0	0.10	0.10	0.50	0.020	0.008

## All Weld Metal Mechanical Properties

	R <sub>p0.2</sub> ( MPa )	R <sub>m</sub> ( MPa )	A <sub>5</sub> ( % )	KV ( J )
Min		520	30	
Max				
Type	480	640	35	+20°C 150

## Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters		Shielding Gas
		Current (A)	Voltage (V)	
TIG = +	2.2	80 - 140	-	ISO 14175: I1 (Ar) 6 - 12 L/min



FT En-CN32-190731

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