FCW 347

Flux cored wire 347 type
High productivity

Classification

AWS A5.22 : E347T0-1/-4 ISO 17633-A : T 19 9 Nb R M21(C1) 3

Description & Applications

Rutile flux cored wire with slag for gas shielded (Ar + CO_2 or 100% CO_2) arc welding of 347 and 321 stainless steel. Easy slag removal and high quality of X-Ray test. Used in flat position only. High productivity.

Main applications: Thermal Plant, piping, construction on sea coast…

Base Materials

UNS	Grade	EN 10088	N° Mat.
S32109	321	X8CrNiTi18-10	1.4941
S34709	347	X8CrNiNb18-10	1.4961

Typical Chemical Composition (%)

	C	Si	Mn	Cr	Ni	Mo	Cu	Nb	Co	P	S	N
Min			0.5	18.0	9.0			8 x C				
Max	0.08	1.0	2.0	21.0	11.0	0.3	0.5	1.0		0.030	0.025	
Type	0.03	0.70	1.4	19.0	10.5	0.10	0.10	0.50	0.04	0.020	0.008	0.06

Ferrite type : 8%

All Weld Metal Mechanical Properties

	$R_{p0.2}$ (MPa)	R_m (MPa)	A_5 (%)	KV (J)	
Min	350	550	30		
Max					
Type	470	650	35	-196°C	34

Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters			Shielding Gas
		Current (A)	Voltage (V)	Stick out (mm)	
FCAW = +	1.2	130 - 270	22 - 35	12 - 25	ISO 14175 : C1 (100% CO_2) M21 (Ar + CO_2) 10-20 l/min

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