

SW-347 Cored

Type : Rutile

Conformances

AWS A5.22/ ASME SFA5.22 E347T1-1/-4

JIS Z3323 TS347-FB1

EN ISO 17633-A-T 19 9 Nb P M21/C1 2

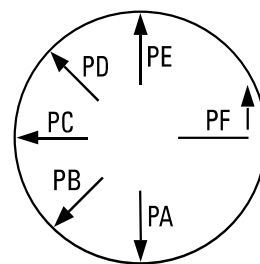
Applications

- Stainless steel boilers and gas turbine
- 347 and 321 type stainless steels

Features

- Good performance in all positions

Welding Position



Current

DC +

Shielding Gas

100% CO₂

Ar + 20~25% CO₂

Diameter / Packaging

Diameter mm (in)	Spool			Pac		
	5kg (11lbs)	12.5kg (27.6lbs)	15kg (33lbs)	250kg (551lbs)	300kg (661lbs)	350kg (771lbs)
0.9 (0.035)	✓	✓	✓			
1.2 (0.045)	✓	✓	✓			
1.6 (1/16)		✓	✓			

Typical Chemical Composition of All-Weld Metal (%)

	C	Si	Mn	P	S	Cr	Ni	Nb
100% CO ₂	0.053	0.72	1.20	0.014	0.008	18.71	10.12	0.60
80% Ar + 20% CO ₂	0.053	0.72	1.15	0.014	0.008	18.81	10.12	0.60

Typical Mechanical Properties of All-Weld Metal

	TS MPa(lbs/in ²)	EL (%)	Temp °C(°F)	CVN-Impact Value J (ft-lbs)
100% CO ₂	640 (92,800)	40.8	-60 (-76)	53 (39.1)
80% Ar + 20% CO ₂	648 (93,960)	40.6	-60 (-76)	52 (38.3)

Typical Welding Parameters

Diameter, Polarity Shielding Gas	CTWD mm (in)	Wire Feed Speed m/min (in/min)	Amp. (A)	Volt. (V)	Deposition Rate kg/hr (lb/hr)
1.2mm (0.045 in) DC+					
100% CO ₂	20 (4/5)	6.5 (256)	140	23~26	2.6 (5.7)
		9.2 (362)	180	27~30	3.7 (8.2)
		12.5 (492)	210	28~31	4.8 (10.6)
80% Ar + 20% CO ₂	20 (4/5)	6.2 (244)	140	23~26	2.7 (6.0)
		9.0 (354)	180	27~30	3.7 (8.2)
		12.0 (472)	210	27~30	4.9 (10.8)
1.6mm (1/16 in) DC+					
100% CO ₂	25 (1)	3.8 (150)	180	24~27	3.2 (7.1)
		6.5 (256)	250	25~28	4.5 (9.9)
		9.0 (354)	290	26~29	5.6 (12.3)
80% Ar + 20% CO ₂	25 (1)	3.7 (146)	180	24~27	3.3 (7.3)
		6.4 (252)	250	25~28	4.8 (10.6)
		8.9 (350)	290	26~29	5.9 (13.0)

SMAW

SAW

GMAW

GTAW

FCAW

Non-FERROUS

APPENDIX