KFW-347

Shielding Gas: CO_2 or Ar+20%CO_2

Classification

AWS	A5.22	E347T1-1/4
JIS	Z3321	TS347-FB1
EN	17633-A	T 19 9 Nb P C1/M21 2
GB	T 17853	E347T1-1/4

Applications and Features

(1) Weld metal is 19.5% Cr-10% Ni-Nb, which adds Nb in order to reduce carbide precipitation.

(2) It is suitable for welding AISI 347, 321, 304L and 302 stainless steel.

Welding Position

All Positions

Welding Instruction

(1) During Welding, the base metal of the weld deposit will dilute and produce ferrite or pure austenitic, which will increase the bead cracking resistance.

(2) For other instructions, please refer to Appendix D.

(3) For extra information, please refer to Appendix F.

Typical Chemical Composition of Weld Metal (wt %) (Shielding Gas : CO_2)

C	Si	Mn	P	S	Cr	Ni	Nb
0.035	0.49	1.68	0.028	0.005	19.15	10.56	0.56

Typical Mechanical Properties of Weld Metal (Shielding Gas : CO_2)

Tensile Strength N/mm^2（kgf/mm^2）	Elongation %
550(56.1)	40

Size and Suggested Operating Range (DC+)

Diameter (mm)	F/H-fillet		V/OH	
	Amp	Volt	Amp	Volt
1.2	100~300	20~36	100~200	24~30
1.6	200~360	26~40	—	—