

GMAW Solid Wire for Stainless Steel

KMS-347

Classification

AWS A5.9/A5.9M ER347

JIS Z3321 YS347

EN 14343-A G 19 9 Nb

YB T5092 H08Cr20Ni10Nb

Shielding Gas: Ar+1~2%O₂(CO₂)

Applications and Features

- (1) Weld metal is austenitic structure with 19%Cr-9%Ni-Nb.
- (2) The addition of niobium reduces intergranular corrosion in severe operating conditions.
- (3) Ideal for welding AISI 308L, 321 and 347 stainless steel plates.

Welding Position



Welding Instruction

- (1) Use Ar+1~2%O₂ for spray transfer and Ar+1~2%CO₂ for short-circuit transfer.
- (2) For other instructions, please refer to Appendix B and F.

Typical Chemical Composition of Weld Metal (wt%)

C	Si	Mn	P	S	Cr	Ni	Nb
0.04	0.41	1.63	0.014	0.010	20.42	9.97	0.78

Typical Mechanical Properties of Weld Metal

Tensile Strength N/mm ²	Yield Strength N/mm ²	Elongation %
620	450	41

Size and Suggested Operating Range (DC+)

Diameter (mm)	0.8	0.9	1.0	1.2	1.4	1.6	
Ar+1~2%CO ₂	Current (A)	40~120	60~140	80~160	100~210	-	-
	Voltage (V)	15~20	15~21	16~22	17~22	-	-
Ar+1~2%O ₂	Current (A)	160~210	170~260	180~280	200~300	210~320	220~330
	Voltage (V)	24~28	24~30	24~30	24~30	24~32	24~32