

KFT-X347

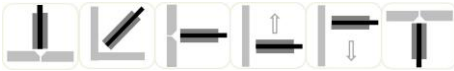
Classification

AWS A5.22/A5.22M	R347T1-5
JIS Z3323	TS3347-RI
EN ISO 17633-B	TS347-RI
GB T17853	R347T1-5

Shielding Gas: 100% Ar

Applications and Features

- (1) KFT-X347 produces slag to protect the reverse side of the root pass from oxidation by the atmosphere and saves the cost for back shielding gases and gas purging downtime including the setting time for gas purging jigs.
- (2) Suitable for welding 18%Cr-8%Ni-Nb steel (AISI 347) and 18%Cr-8%Ni-Ti steel (AISI 321).

Welding Position**Welding Instruction**

- (1) Formation of key-hole during welding is very important in order to supply slag onto reverse side bead.
- (2) The melting rate of flux cored wire is higher than that of solid wire due to flux addition. The speed of wire feeding must be higher.
- (3) Only for root pass in single-side welding, not for cover pass.

Typical Chemical Composition of Weld Metal (wt%)

C	Si	Mn	P	S	Cr	Ni	Nb
0.03	0.82	1.57	0.020	0.011	19.15	9.32	0.65

Typical Mechanical Properties of Weld Metal

Tensile Strength	Yield Strength	Elongation
N/mm ²	N/mm ²	%
617	438	40

Size and Polarity (DC-)

Diameter (mm)	2.2
Length (mm)	1000