

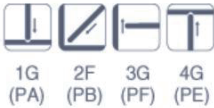
E347T1-1

AWS A5.22 E347T1-1/4

Description:

E347T1-1 is a stainless steel gas shielded flux-cored wire designed for all positional welding, can be used to weld 347 and 321 stainless steel. The weld deposit has 5-15% ferrite, Niobium (Nb) is used as the stabilized element to prevent intergranular corrosion. Used to weld important anti-corrosion steel which contain Nb or nickel-chrome alloys which Ti as the stabilized element .

Welding Position:



Diameters:

1,2mm, 1,6mm

Typical Mechanical Properties:

Tensile strength(MPa):	550
Yield strength(MPa):	--
Elongation(%):	39
Impact values(≥ 27)/(-196 $^{\circ}$ C):	35

Typical Chemical Compositon:

C	Mn	P	S	Si	Ni	Cr	Mo	Cu
0,05	1,60	0,010	0,010	0,60	10,0	20,0	0,01	0,03

—

Welding Current:(DC+)

Diameter(mm)	1,2	1,6
Current/A	120-220	180-300
Voltage/V	20-32	20-32
Gas speed/(L/Min)	20-25	20-25

Note:

- 1.Shield gas: 100% CO₂ or 80% Ar+20% Co₂ .
2. Preheat before welding.
3. Interpass temperature: $\leq 80^{\circ}$ C