Selectarc WELDING

FCW 347

Flux Cored Wire

Classification

AWS A5-22 : E347 T0 - 1/4

EN ISO 17633-A : T19 9 Nb T M3 / C3

MaterialN° : 1.4551

Characteristics

Rutile type flux cored wire to weld with shielding gas protection 18%Cr-8%Ni type stainless steel Niobium / Columbium stabilised, suited to weld Ti or Nb stabilised stainless steels. The weld deposit is resistant to intercrystalline corrosion for service temperatures upto 400°C. Excellent weldability and suitable for use with ceramic backing. Excellent weld metal quality and X-ray soundness.

Applications

For welding Steels that are exposed to working temperatures upto 400°C. As well as for cladding/Weld overlay.

Base Materials

UNS	Alloy	EN	Material N°	UGINE
S 30400	304	X5CrNi18-10	1.4301	UGINOX 18-9 B,D,E
S 30403	304L	X2CrNi19-11	1.4306	UGINOX 18-10 L
S 32100	321	X6crNiTi18-10	1.4541	UGINOX 18-10 T
S 34700	347	X6CrNiNb18-10	1.4550	

Typical Weld Metal Composition (%)

C	Si	Mn	Cr	Ni	Mo	Cu	Nb	P	S	Fe
0.030	0.60	1.40	19.50	10.50	0.10	0.080	0.50	0.020	0.010	base

All Weld Metal Mechanical Properties (Typical)

Conditions	UTS Rm (MPa)	YS Rp0.2 (MPa)	% Elg A_5	Impact (KV) Temp.°C	J	LE (mm)
AW	650	450	35	- 196	34	0.30

Welding Current & Instructions

Welding Mode	Ø Wire (mm)	Welding Mode			Shieding Gas
		Current (A)	Voltage (V)	Stick-out (mm)	ISO 14175
FCAW = +	1.2	120 - 250	23 - 30	15 - 20	M21 (Ar+10-20 %Co_2) or CO_2 18 - 20 l/min

Welding Positions : 1G/PA ; 2G/PC ; 1F ; 2F/PB

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