



FCW 347H

All positions 347H type
Flux cored wire

Classification

ISO 17633-A : T 19 9 Nb P M21 1 (C1 1)
AWS A5.22 : E347T1-1/-4

Description & Applications

Flux cored wire for gas shielded arc welding for 347H and 321H stainless steel specifically designed for work in all positions. Attractive appearance and very good penetrations

Main applications: All type of steel construction with a service temperature do not exceed 400°C. Thermal Plant, piping, construction on sea coast

Base Materials

UNS	Grade	EN 10088	N° Mat.
S32109	321H	X8CrNiTi18-10	1.4941
S34709	347H	X8CrNiNb18-10	1.4961

Typical Chemical Composition (%)

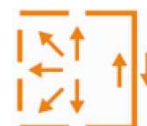
C	Si	Mn	Cr	Ni	Nb	P	S	Fe
0.06	0.9	1.4	19.5	10.5	0.7	<0.02	<0.01	Rem.

All Weld Metal Mechanical Properties

R _{p0.2} (MPa)	R _m (MPa)	A ₅ (%)	KV (J)
470	620	35	+ 20°C 60

Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters		Stick out (mm)	Shielding Gas
		Current (A)	(V)		
= +	1.2	130 – 270	22 – 35	12 - 25	ISO 14175 : C1 / M21 10-20 l/min



FT En-C067JC-1503

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