

Classifications

EN ISO 17633-A:2008	: T 19 9 Nb P C 1	KS D 3612	: YF-347LC
EN ISO 17633-B:2008	: TS347-FC1	JIS Z 3323	: TS347L-FC1
AWS A5.22-15	: E347T1-1		

Description

- K-347T is formulated for MAG welding of 19%Cr-9%Ni-Nb stainless steels. (AISI 347, 321, ASTM A296; A157 Gr. C9; A320 Gr. B8C or D)
- Wire is a titania type of flux cored wire for all-position welding and it has low spatter generation, easy slag removal and good weld soundness.
- Nb component improves the resistance to intergranular corrosion of the weld metal.
- The weld metal contains optimum ferrite contents in their austenitic structures, Therefore their weldability is excellent with lower crack susceptibility.

Welding positions**Polarity & shielding gas**

- CO₂: 100% CO₂ (15~25ℓ/min)
- DCEP (DC+)

Typical chemical composition of all-weld metal (%)

Shielding gas	C	Si	Mn	Cr	Ni	Nb	FN
CO ₂	0.04	0.68	1.15	19.70	10.10	0.56	7.0

Typical mechanical properties of all-weld metal

	Y.S (MPa)	T.S (MPa)	El. (%)	IV (J)		Remarks
				-60°C	-105°C	
AWS A5.22		min. 520	min. 30			
EN ISO 17633-B	min. 350	min. 520	min. 25			
Example	480	650	33	50	40	CO ₂

Notes on usage and welding condition

- Refer to page 303 for more information on usage
- When heat input is excessive, the impact value tends to be reduced. Therefore, perform welding with selecting proper heat input

Package

Dia. (mm)	0.9	1.2	1.6
Spool (kg)	5, 12.5, 15		