

SW-347 Cored

TYPE : Rutile

AWS A5.22/ASME SFA5.22 E347T1-1/-4
JIS Z3323 TS347-FB1
EN ISO 17633-A-T 19 9 Nb P M/C 2

Applications

Main uses are for the welding of stainless steel boilers and gas turbines.

Characteristics on Usage

SW-347 Cored is a titania type flux cored wire designed for welding of 347 and 321 type stainless steels.

Notes on Usage

① Use with 100% CO₂ or Ar + 20~25% CO₂ gas.

Welding Position



1G 2F 3G 4G
(PA) (PB) (PF) (PE)

Current

DC +

Shielding Gas

CO₂/Ar+20~25%CO₂

Typical Chemical Composition of All-Weld Metal (%) (Shielding Gas: 100% CO₂)

C	Si	Mn	P	S	Cr	Ni	Nb
0.04	0.80	1.20	0.025	0.010	19.5	10.0	0.40

Typical Mechanical Properties of All-Weld Metal (Shielding Gas: 100% CO₂)

TS MPa(lbs/in ²)	EL (%)	Temp. °C (°F)	CVN-Impact Value J (ft · lbs)
610 (88,500)	45	-20 (-4)	60 (44)

Approval

I Packing(Including Ball Pac)

Dia. (mm)	1.2	1.6	Spool(kg)	5	12.5	15
(in)	.045	1/16	(lbs)	11	28	33

Sizes Available and Recommended Currents (Amp.)

Size mm (in)	1.2 (.045)	1.6 (1/16)
F & HF	180~220	250~290
V-up,OH	120~160	-