

## AA 347 TIG

**CATEGORY** FCAW Flux-Cored

**TYPE** Flux cored stainless steel welding wire for Tig welding

**APPLICATIONS** Boilers, shipbuilding, machinery, offshore application, foundries, chemical industry, root pass welding when backing gas is not available or preferred.

**PROPERTIES** These are all rutile flux cored TIG filler rods for root pass welding of stainless steel pipe without the need for a reverse side back purge (internal shielding gas). As they produce a slag, they are not recommended for multi-pass welding.

**CLASSIFICATION**  
 AWS A 5.22: R 347T1-5  
 EN ISO 1.4551  
 DIN: W.Nr. 1.4551

**SUITABLE FOR** Suitable for 18%Cr-8%Ni+Ti or 18%Cr-8%Ni+Nb stabilized stainless steel.

**APPROVALS** CE approved

**WELDING POSITIONS:**



**PURE WELD DEPOSIT**

C	Mn	Si	Cr	Ni	Nb+Ta	S	P	FS	FN
0,02	1,60	0.80	19.0	10.2	0.7	0.004	0.021	9	13

**MECHANICAL PROPERTIES**

Heat treatment	R <sub>p0,2</sub> (N/mm <sup>2</sup> )	R <sub>m</sub> (N/mm <sup>2</sup> )	A <sub>5</sub> (%)	Impact energy (J) ISO-V +20°C	Impact energy (J) ISO-V -40°C	Impact energy (J) ISO-V -120°C	Hardness HRc / HV
as welded	460	630	48	130			

**WELDING PARAMETERS / PACKING**

Parameters			Packing		
plate thickness (mm)	Root gab (mm)	Current DC-	diameter (mm)	kg	kg / master carton
3-5	2	80-90	2.2 x 1000	5	20
6-16	2.4	90-105			
>10	2.8	90-110			

**REDRYING TEMPERATURE** 150°C/24hr

**GAS ACC. EN ISO 14175:** I1