

AA 347H

CATEGORY FCAW Flux-Cored

TYPE Rutile fluxcored wire for welding stabilized stainless steel

APPLICATIONS For welding stainless austenitic steels that are exposed to working temperatures up to + 400°C.

PROPERTIES The weld deposit is scale-resistant up to approx. 800°C in normal atmosphere and oxidizing gases. The weld deposit is capable of taking a high polish. Structure: Austenite with delta ferrite. This fluxcored wire offers higher productivity, higher deposition rate and improved wetting properties due to slag support especially in positional welding. Excellent weldability and suitable for use with ceramic backing strips. Excellent weld metal quality and X-ray soundness.

CLASSIFICATION

AWS	A 5.22: E 347 T1-1/4
EN ISO	17633-A: T 19 9 Nb P C/M 2
DIN: W.Nr.	1.4551
DIN	8556: 19 9 Nb

SUITABLE FOR

1.4541	X 6 CrNiTi 18 10	1.4301	X 5 CrNi 18 10
1.4550	X 6 CrNiNb 18 10	1.4303	X 5 CrNi 18 12
1.4552	G-X 5 CrNiNb 18 9	1.4308	G-X 6 CrNi 18 9
1.4319	X 5 CrNi 18 7	1.4310	X 12 CrNi 17 7
1.4306	X 2 CrNi 19 11	1.4312	G-X 10 CrNi 18 8
1.4306	G-X 2 CrNi 18 9	-	-

Stainless steels for general use : NF A 35-573, 35-574, 35-575, 35-576 : Z6 CNT 18.10, Z6 CN Nb 18.10, Z2 CN 18.10, Z6 CN 18.09. :NS 21 C

APPROVALS CE approved

WELDING POSITIONS:



WELD METAL WEIGHT %

C	Mn	Si	Cr	Ni	Nb	FS	FN	FNW
0.03	1.30	0.60	18.7	10.4	0.6	6.7	7.3	6.3

FS: Schaeffler, FN: De Long, FNW: 1992 WRC

TYPICAL ALL WELD METAL PROPERTIES

Heat Treatment	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness HRc / HV
				+20°C	-40°C	-60°C	
AW	440	617	37	83			

AW: as welded

WELDING PARAMETERS / PACKING

D (mm)	Welding Parameters		Packing		
	Voltage (V)	Current (A)	spool type	kg / spool	kg / pallet
1,2	23-30	150-220	KD-300	15	1080
1,6	25-33	180-280	KD-300	15	1080

REDRYING TEMPERATURE 150°C/24hr

GAS ACCORDING EN 14175: M21