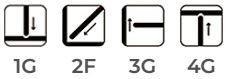
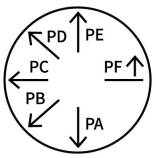
SW-347 Cored

Classification

AWS AWS A5.22/ ASME SFA-5.22 E347T1-1/-4
JIS Z 3323 TS347-FB1
EN ISO 17633-A-T 19 9 Nb P M21/C1 2

Welding Positions





Features

- Good performance in all positions

Polarity

DC +

Application Areas

- Stainless steel boilers and tubine
- 347 and 321 type stainless steels

Shielding Gas

100% CO2
Ar+20~25% CO2

Approvals

ABS
✓

Typical Chemical Composition of All-Weld Metal (wt%)

Shielding Gas	C	Si	Mn	P	S	Ni	Cr	Mo	Nb
100% CO2	0.05	0.7	1.2	0.014	0.008	10.1	18.7	0.01	0.6
Ar + 20% CO2	0.05	0.7	1.2	0.014	0.008	10.1	18.8	0.01	0.6

Typical Mechanical Properties of All-Weld Metal

Shielding Gas	Tensile Strength MPa(ksi)	Elongation (%)	Temperature °C (°F)	Impact Toughness J (ft·lbs)
100% CO2	640(93)	40	-20(0)	58(43)
Ar+20~25% CO2	648(94)	40	-20(0)	59(44)

Diameter / Welding Parameters / Packaging

Wire Diameter mm(in)	Current (A)	Packaging
1.2 (0.045)	160~220	Spool 5kg(11lbs), 12.5(27.6lbs), 15kg(33lbs)
1.6 (1/16)	250~290	