FOR STAINLESS STEEL

AWS E347T1-1
JIS YF347C
KS YF347C

K-347T

Typical applications

K-347T is formulated for MAG welding of 18%Cr-8%Ni-Nb stainless steels.
(AISI 347, 321, ASTM A296; A157 Gr. C9; A320 Gr. B8C or D)

Characteristics on Usage

① Wire is a titania type of flux cored wire for all-position welding.
② Wire has low spatter, easy slag removal and good weld soundness.
③ Nb component improves the resistance to intergranular corrosion of the weld metal.
④ The weld metal contains optimum ferrite contents in their austenitic structures,Therefore their weldability is excellent with lower crack susceptibility.
⑤ The shielding gas should be used 100%CO_2 for welding.
⑥ Refer to page 150 for more information on usage.

Typical chemical composition of all-weld-metal (%)

Shielding Gas	C	Si	Mn	Cr	Ni	Nb
CO_2	0.05	0.63	1.75	19.5	10.5	0.54

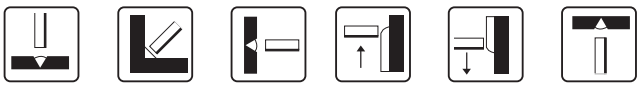
Typical mechanical properties of all-weld-metal

Shielding Gas	T · S N/mm²{kgf/mm²}	El (%)
CO_2	680 {69}	34

Sizes available and recommended currents (DC wire⊕)

Dia. (mm)	Amp.	Electrode extensin (mm)
1.2	100~240	10~20
1.6	160~260	15~25

Welding positions



Approved by

JIS