Technical data sheet 011121MBA	Cored welding wire # TETRA V 347H-G	Welding Alloys

CLASSIFICATION

ASME IIC SFA 5.22 / AWS A 5.22:	E347HT1-4 - E347HT1-1
EN ISO 17633-A:	T 19 9 Nb P M21 1 - T 19 9 Nb P C1 1
EN ISO 17633-B:	TS347H-F M21 1 – TS347H-F C1 1
Equivalent Material number:	1.4551
ASME IX Qualification	QW432 F-N° 6 QW442 A-N° 8

DESCRIPTION

- Rutile flux cored stainless steel wire for gas shielded arc welding
- 19% chromium - 9% nickel - niobium stabilised - high carbon deposit
- Attractive bead appearance, very good penetration and high productivity
- Excellent X-ray soundness
- Specifically designed for out-of-position welding
- Maximum productivity for completion of vertical welds
- Welded with classical economic Ar-CO_2 mixtures or CO_2

APPLICATIONS

TETRA V 347H-G is suitable for welding stabilised stainless steels containing 16 to 21% Cr and 8 to 13% Ni.

Examples:

AISI	UNS	Material number	EN Symbol
321H	S32109	1.4941	X8 CrNiTi 18-10
347H	S34709	1.4961	X8 CrNiNb 16-13

TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr	Ni	Nb	S	P
0.06	1.4	0.9	19.5	10.5	0.7	0.008	0.020

Typical ferrite level: 6 FN

MINIMUM ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2% [MPa]	A_5 [%]	CVN [J]
550	350	25	+20°C: 47

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2%[MPa]	A_5 [%]	CVN [J]
620	470	35	+20°C: 60

SHIELDING GAS

M21 (Ar + 15 - 25% CO_2), M20 (Ar + 5%< CO_2 ≤ 15%) gas mixtures or C1 (CO_2) according to EN ISO 14175

OPERATING CONDITIONS

Diameter [mm]	Current type	Intensity [A]	Voltage [V]	Stick-out [mm]	Gas flow
1.2	DC (+)	130 - 270	22 - 35	12 - 25	10 - 20 l/min.

WELDING POSITIONS

All positions

PACKAGING

Diameter	1.2 mm	
Spool type	EN ISO 544 – ASME IIC SFA-5.2 M	
	S200	BS300
Weight	5 kg	15 kg

Other packaging and other diameters: please consult us