Technical data sheet 011121MBA	Cored welding wire # TUBE S 347H-S	Welding Alloys

CLASSIFICATION

ASME IIC SFA 5.9 / AWS A 5.9:	EC347
ASME IIC SFA 5.22 / AWS A 5.22:	EC347
EN ISO 17633-A:	T 19 9 Nb M NO 3
EN ISO 17633-B:	TS347-M NO 0

DESCRIPTION

- Cored stainless steel wire for submerged arc welding
- 19% chromium - 9% nickel - niobium stabilised - high carbon deposit
- Attractive bead appearance without residual slag, outstanding slag release even in narrow gaps
- High productivity and enhanced wetting properties compared to matching solid wires
- Mineral additions to the core improve both mechanical characteristics and resistance to cracking

APPLICATIONS

TUBE S 347H-S is suitable for welding the higher carbon stabilised stainless steels containing 16 to 21% Cr and 8 to 13% Ni.
The deposit has controlled delta ferrite content and is designed for use above 550°C.

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	1.40	0.60	19.5	10.5	0.70	0.008	0.020

Typical ferrite level: 8 FN

MINIMUM ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2% [MPa]	A_5 [%]	CVN [J]
520	320	30	+20°C: 27

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2%[MPa]	A_5 [%]	CVN [J]
640	450	35	+20°C: 70

FLUX DESCRIPTION

	WA FLUX 325	WA FLUX 385	WA FLUX 415	WA ULTRAFLUX
EN ISO 14174 class	S A AB 1 65	S A AF 2 64	S A FB 1 55	S A FB 1 55

PACKAGING

Diameter	1.6 mm - 3.2 mm
Standard packaging	EN ISO 544 - ASME IIC SFA-5.2 M
	Coil: B450
Weight	25 kg

Other packaging and other diameters: please consult us