

**Technical data sheet**

011121MBA

**Cored welding wire**  
**TETRA S 347L-G****CLASSIFICATION**

ASME IIC SFA 5.22 / AWS A 5.22:	E347T0-4 - E347T0-1
EN ISO 17633-A:	T 19 9 Nb R M21 3 - T 19 9 Nb R C1 3
EN ISO 17633-B:	TS347L-F M21 0 – TS347L-F C1 0
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 - low carbon deposit
- Attractive bead appearance, easy slag release, very good penetration and high productivity
- Excellent X-ray soundness
- Maximum performance in the flat and horizontal positions
- Welded with classical economic Ar-CO<sub>2</sub> mixtures or CO<sub>2</sub>

**APPLICATIONS**

TETRA S 347L-G is suitable for welding stabilised stainless steels containing 16 to 21% Cr and 8 to 13% Ni as well as for cladding / weld overlay.

**Examples:**

AISI	UNS	Material number	EN Symbol
321	S32100	1.4541	X6 CrNiTi 18-10
347	S34700	1.4550	X6 CrNiNb 18-10

**APPROVALS**

TÜV (09297.02), DB (43.128.12)

**TYPICAL ALL-WELD METAL ANALYSIS**

C	Mn	Si	Cr	Ni	Nb	S	P
0.03	1.40	0.70	19.0	10.5	0.50	0.008	0.020

Typical ferrite level: 8 FN

**MINIMUM ALL-WELD METAL MECHANICAL PROPERTIES**

Rm [MPa]	Rp0.2% [MPa]	As [%]	CVN [J]
550	350	25	-196°C: 27

**TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES**

Rm [MPa]	Rp0.2% [MPa]	As [%]	CVN [J]
650	470	35	-196°C: 34

**SHIELDING GAS**

M21 (Ar + 15 - 25% CO<sub>2</sub>), M20 (Ar + 5% < CO<sub>2</sub> ≤ 15%) gas mixtures or C1 (CO<sub>2</sub>) according to EN ISO 14175

**OPERATING CONDITIONS**

Diameter [mm]	Current type	Current [A]	Voltage [V]	Stick-out [mm]	Gas flow rate
0.9	DC+	80 - 250	18 - 32	10 - 20	12 - 20 l/min.
1.2	DC+	100 - 280	23 - 33	10 - 25	12 - 20 l/min.
1.6	DC+	150 - 400	23 - 35	10 - 25	12 - 20 l/min.

**WELDING POSITIONS**

Flat, Horizontal

**PACKAGING**

Diameter	1.0 mm		1.2 mm		1.6 mm
Spool type	EN ISO 544 – ASME IIC SFA-5.2 M				
	S200	BS300	S200	BS300	BS300
Weight	5 kg	15 kg	5 kg	15 kg	15 kg

Other packaging and other diameters: please consult us

Welding products and techniques evolve constantly. All descriptions, illustrations and properties given in this data sheet are subject to change without notice and can only be considered as suitable for general guidance. This document is intended to help the user make the correct choice of product. It is his responsibility to assess its suitability for his intended application.