

Technical data sheet

011121MBA

Cored welding wire
TUBE S 347H-G**CLASSIFICATION**

ASME IIC SFA 5.22 / AWS A 5.22:	EC347
ASME IIC SFA 5.9 / AWS A 5.9:	EC347
EN ISO 17633-A:	T 19 9 Nb M M12 1
EN ISO 17633-B:	TS347-M M12 1
Equivalent Material number:	1.4551
ASME IX Qualification	QW432 F-N° 6 QW442 A-N° 8

DESCRIPTION

- Metal cored stainless steel wire for gas shielded arc welding
- 19% chromium - 9% nickel - niobium stabilised deposit
- Enhanced productivity, improved weldability, better wetting properties compared to solid wires
- Excellent weld metal quality and X-ray soundness

APPLICATIONS

TUBE S 347H-G is suitable for welding the higher carbon stabilised stainless steels containing 16 to 21% Cr and 8 to 13% Ni.

The deposit has a controlled delta ferrite content and can be used 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: 5 FN

MINIMUM ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2% [MPa]	As [%]	CVN [J]
520	320	30	+20°C: 47

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

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

SHIELDING GAS

EN ISO 14175:	M12	Ar + 0.5 % < CO ₂ ≤ 2.5 with or without helium
	Z	Ar + CO ₂ ≤ 0.5 % or O ₂ ≤ 0.5 % with or without helium
	I1	Ar
	M13	Ar + 0.5 % < O ₂ ≤ 3.0 with or without helium

OPERATING CONDITIONS

Current type	Gas flow rate	Stick out	Recovery
DC+ / pulsed	10 - 20 l/min.	12 - 25 mm	98 %

WELDING POSITIONS

EN ISO 6947: PA, PB.

ASME IX: 1G, 1F, 2F.

TUBE S 347L-G is primarily used in the flat and horizontal positions. However, welds in other positions are also possible using the short-circuiting or pulsed arc modes of transfer.

PACKAGING

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

Other packaging and other diameters: please consult us

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