

**Technical
data sheet**

011121MBA

**Cored welding wire
TUBE S 347H-S****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]	As [%]	CVN [J]
520	320	30	+20°C: 27

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2% [MPa]	As [%]	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

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.