


Technical data sheet <small>011121MBA</small>	Cored welding wire TUBE S 347L-S	
---	---	---

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 NO 3
Equivalent Material number:	1.4551
ASME IX Qualification	QW432 F-N° 6 QW442 A-N° 8

DESCRIPTION

- Cored stainless steel wire for submerged arc welding
- 19% chromium - 9% nickel - niobium stabilised - low carbon deposit
- Excellent weld metal quality and X-ray soundness
- High productivity
- Enhanced wetting properties compared to matching solid wires

APPLICATIONS

TUBE S 347L-S is suitable for welding stabilised stainless steels containing 16 to 21% Cr and 8 to 13% Ni

Examples:

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

TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr	Ni	Nb	S	P
0.02	1.50	0.55	20.0	10.5	0.50	0.008	0.020

Typical ferrite level: 10 FN

MINIMUM ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2% [MPa]	A5 [%]	CVN [J]
520	320	35	-196°C: 27

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2% [MPa]	A5 [%]	CVN [J]
600	430	35	-196°C: >27

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.