| Technical data sheet<br>011121MBA | Cored welding wire<br># TUBE S 347L-S | Welding Alloys |
|---|---|---|

## 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