


Technical data sheet 011121MBA	Flux cored GTAW rod WAROD 347	 Welding Alloys
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CLASSIFICATION

ASME IIC SFA 5.22 / AWS A 5.22: R347T1-5

DESCRIPTION AND APPLICATIONS

- Flux cored filler rod for TIG welding
- Produces slag to protect the reverse side of the root pass from oxidation by the atmosphere
- Saves the costs for back shielding gases
- Eliminates gas purging downtime, perfectly suited for stainless steel pipe welding
- Applicable from 0°C to + 350°C

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	Fe
0.04	1.40	0.70	19.0	10.5	0.50	Bal.

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES (as per ASME II Part C SFA 5.22)

Rm [MPa]	Rp0.2% [MPa]	As [%]	CVN [J]
620	460	45	+20°C: 140

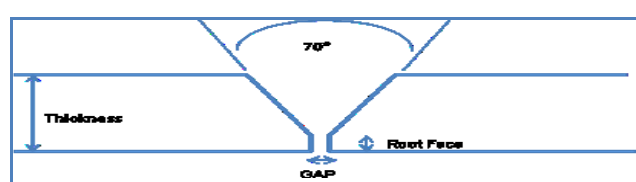
SHIELDING GAS

EN ISO 14175: I1 (100% Ar)

OPERATING CONDITIONS

Rod Ø x L [mm]	2.2 x 1000
Current [A]	80 - 140

Welding parameters depend on plate thickness. Typical weld preparation and welding parameters:

	Thickness [mm]	GAP [mm]	Root face [mm]	Current [A]
	3 - 5	2.0-4.0	1.0	80 - 95
	5 - 10	2.0-4.0	1.0	90 - 110
	10 -	2.0-4.0	1.0	105 - 140

WELDING POSITIONS

All positions

PACKAGING

Rod Ø x L [mm]	2.2 x 1000
Weight/box [kg]	5

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.