

SW-347 Cored

Type : Rutile

SW-347 Cored

Conformances

AWS A5.22 / ASME SFA5.22 E347T1-1/-4
 JIS Z3323 TS347-FB1
 EN ISO 17633-A-T 199 Nb P M/C 2

Applications

- Stainless steel boilers and gas turbine
- 347 and 321 type stainless steels

Features

- Good performance in all positions

Welding Position



1G 2F 3G 4G
 (PA) (PB) (PF) (PE)

Current

DC +

Shielding Gas

100% CO₂
 Ar + 20~25% CO₂

Typical Chemical Composition of All-Weld Metal (%)

	C	Si	Mn	P	S	Cr	Ni	Nb
100% CO ₂	0.04	0.60	1.40	0.02	0.01	19.3	9.9	0.40
80% Ar + 20% CO ₂	0.04	0.60	1.50	0.02	0.01	19.5	10.0	0.40

Typical Mechanical Properties of All-Weld Metal

	TS Mpa(lbs/in ²)	EL (%)	Temp °C(°F)	CVN-Impact Value J (ft.-lbs)	Ferrite Number
100% CO ₂	610 (88,450)	38	-20 (4)	50 (37)	8-10
80% Ar + 20% CO ₂	620 (89,900)	37	-20 (4)	55 (41)	8-10

Typical Operating Procedures

Diameter, Polarity Shielding Gas	CTWD mm (in)	Wire Feed Speed m/min (in/min)	Voltage (volts)	Approx. Current (amps)	Deposition Rate kg/hr (lb/hr)
1.2mm (0.045 in) DC+					
100% CO ₂	20 (4/5)	6.5 (256)	23-26	140	2.6 (5.7)
		9.2 (362)	27-30	180	3.7 (8.2)
		12.5 (492)	28-31	210	4.8 (10.6)
80% Ar + 20% CO ₂	20 (4/5)	6.2 (244)	23-26	140	2.7 (6.0)
		9.0 (354)	27-30	180	3.7 (8.2)
		12.0 (472)	27-30	210	4.9 (10.8)
1.6mm (1/16 in) DC+					
100% CO ₂	25 (1)	3.8 (150)	24-27	180	3.2 (7.1)
		6.5 (256)	25-28	250	4.5 (9.9)
		9.0 (354)	26-29	290	5.6 (12.3)
80% Ar + 20% CO ₂	25 (1)	3.7 (146)	24-27	180	3.3 (7.3)
		6.4 (252)	25-28	250	4.8 (10.6)
		8.9 (350)	26-29	290	5.9 (13.0)

Diameter / Packaging

Diameter mm (in)	Spool			Pac		
	5kg (11lbs)	12.5kg (27.6lbs)	15kg (33lbs)	250kg (551lbs)	300kg (661lbs)	350kg (771lbs)
0.9 (0.035)	✓	✓	✓			
1.2 (0.045)	✓	✓	✓			
1.6 (1/16)		✓	✓			