



TUBE S 347L-G

CLASSIFICATION

ASME IIC SFA 5.9 / AWS A 5.9:	EC347
EN ISO 17633-A:	T 19 9 Nb M M 1
EN ISO 17633-B :	T8347-MG1
Equivalent Material number:	1.4551
ASME IX Qualification	QW432 F-N° 6 QW442 A-N° 8

DESCRIPTION

- Metal cored stainless steel wire for gas shielded arc welding
- 19% chromium - 9% nickel - niobium stabilised - low carbon deposit
- Enhanced productivity, improved weldability, better wetting properties compared to solid wires
- Excellent weld metal quality and X-ray soundness

APPLICATIONS

Tube S 347L-G 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	X5 CrNiTi 18-10
347	S34700	1.4550	X5 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%

MINIMUM ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2% [MPa]	A ₅ [%]	KV [J]
520	320	30	-105°C : 27

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2% [MPa]	A ₅ [%]	KV [J]
620	430	35	-105°C : 45

SHIELDING GAS

EN ISO 14176 :	M12	Ar + 0.5 % < CO ₂ ≤ 2.6 with or without Helium
	Z	Ar + CO ₂ ≤ 0.5 % or O ₂ ≤ 0.5 % with or without Helium
	I1	Ar
	M13	Ar + 0.5 % < O ₂ ≤ 3.0 with or without Helium

OPERATING CONDITIONS

Current type	Gas flow rate	Stick out	Recovery
DC (+)pulsed	10 - 20 l/min.	12 - 25 mm	98 %

WELDING POSITIONS

EN ISO 6947:	PA, PB.
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ASME IX: 1F, 1G, 2F.

Tube S 347L-G is primarily used in the flat and horizontal-vertical positions. However, welds in other positions are also possible using the short-circuiting or pulsed arc modes of transfer.

PACKAGING

Diameter	1.2 mm	1.8 mm
	EN ISO 544 – ASME II C SFA-5.2 M	
Spool type	S200	B8300
Weight	5 kg	15 kg

Other packaging: please consult us