

CODIFICATION: AWS/SFA 5.9: ER347

CHARACTERISTICS AND APPLICATIONS:

FW 347 is a solid wire for TIG welding, available in bright finish, gives smooth flow, stable arc and spatter free under optimum welding conditions. It gives radiographic quality weld deposit. The Nb reduces the possibility of intergranular chromium carbide precipitation and thus susceptibility to intergranular corrosion and high temperature strength. It is suitable for welding Cr – Ni stabilized stainless steels of type AISI 347, 321, etc.

TYPICAL CHEMICAL COMPOSITION OF SOLID WIRE:

| Element | C | Mn | Si | S | P | Cr | Ni | Nb |
|---------|------|------|------|-------|-------|-------|-----|------|
| Percent | 0.04 | 1.40 | 0.37 | 0.010 | 0.015 | 19.15 | 9.5 | 0.55 |

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL:

| UTS (MPa) | Elongation (L=4d) % |
|-----------|---------------------|
| 580 | 33.0 |

SHIELDING GAS : Argon

CURRENT CONDITIONS : DCEN

WELDING POSITION : H, F, VU, OH

PACKING:

| | |
|----------------------|--|
| STANDARD SIZE | Diameter 1.6 mm, 2.0 mm, 2.50 mm & 3.20 mm in cut lengths of 1000 mm each. |
| QUANTITY | 5 kgs wire put in an air-tight polythene bag and finally packed in a plastic container. Identification – AWS code is punched on both the sides of wire. |

An ISO 9001: 2008 certified company

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