

DESCRIPTION

Executive 347 provides superior weldability, low spatter and smooth beads with easy slag removal. Addition of columbium as carbon stabilizer.

Usually used for welding chromium-nickel stainless steel base metals of similar composition stabilized with either Nb or Ti. Although Nb is the stabilizing element usually specified in Type 347 alloys, it should be recognized that tantalum (Ta) is also present. Ta and Nb are almost equally effective in stabilizing carbon and in providing high-temperature strength. If dilution by the base metal produces a low ferrite or fully austenitic weld metal, the crack sensitivity of the weld may increase substantially.

APPLICATIONS & FEATURES

Used for welding of 18% Cr-8% Ni-Ti and 18% Cr-8% Ni-Cb because of its excellent creep-rupture property at high temperature.

TYPICAL WIRE CHEMISTRY & MECHANICAL PROPERTIES

C	Cr	Ni	Mo	Mn	Si	P	S	Cb	N	
0.05	19.16	9.68	0.55	1.64	0.39	0.021	0.01	0.63	0.012	
Tensile Strength:		81,400 PSI min						Elongation:		37%
Yield Strength:		62,269 PSI min								

TYPICAL WELDING PARAMETERS

Diameter	Voltage	Amperage	WFS (in/min)	Shielding Gas*
.045"	24	130	225	100% CO ₂ or Ar + 20-25% CO ₂
.045"	27	175	320	
.045"	30	240	530	
.062"	27	195	152	100% CO ₂ or Ar + 20-25% CO ₂
.062"	31	260	260	
.062"	34	320	360	

*Shielding gas flow rate 35 to 50 CFH. For 100% CO₂ use two volts higher than shown

STANDARD PACKAGING

FCAW 33-lb plastic spools 1,980-lb pallet

CLASSIFICATION

AWS/SFA 5.22, Class **E347T0-1/4**

