

KM-347

Classification

Shielding Gas:	Ar+1~2%O ₂	AWS A5.9/A5.9M	ER347
	Ar+1~2%CO ₂	AS/NZS ISO 14343	B SS347

Applications and Features

- (1) Weld metal is austenite structure with 20%Cr-10%Ni-Nb.
- (2) Better intergranular corrosion resistance and strength at high temperature than 308LSi due to Nb content.
- (3) Ideal for welding AISI 308L, 321 and 347 stainless steel plates.

Welding Instruction

- (1) Use Ar blend with 1~2%O₂ for high current, spray transfer welding .
- (2) Use Ar blend with 1~2%CO₂ for low current, short-circuit transfer welding.

Typical Chemical Composition of Wire (wt%)

C	Si	Mn	P	S	Cr	Ni	Nb
0.035	0.41	1.63	0.014	0.010	20.42	9.97	0.78

Typical Mechanical Properties of Weld Metal (Shielding Gas : Ar+2% O₂)

Tensile Strength MPa	Yield Strength MPa	Elongation %
620	450	41

Size and Suggested Operating Range (DC+)

Shielding Gas		Diameter (mm)	
		0.9	1.2
Ar+1~2%CO ₂	Amp	60~140	100~210
	Volt	15~21	17~22
Ar+1~2%O ₂	Amp	170~260	200~300
	Volt	24~30	24~30

Diam.	15 kg Spool
0.9mm	KM3470915
1.2mm	KM3471215

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