

# SW-347 Cored

Type : Rutile

## Conformances

AWS A5.22/ ASME SFA5.22 E347T1-1/-4  
JIS Z3323 TS347-FB1  
EN ISO 17633-A-T 19 9 Nb P M21/C1 2

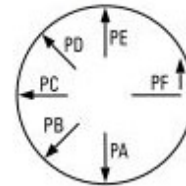
## Applications

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

## Features

- Good performance in all positions

## Welding Position



## Current

DC +

## Shielding Gas

100% CO<sub>2</sub>  
Ar + 20~25% CO<sub>2</sub>

## Typical Chemical Composition of All-Weld Metal (%)

	C	Si	Mn	P	S	Cr	Ni	Nb
100% CO <sub>2</sub>	0.053	0.72	1.20	0.014	0.008	18.71	10.12	0.60
80% Ar + 20% CO <sub>2</sub>	0.053	0.72	1.15	0.014	0.008	18.81	10.12	0.60

## Typical Mechanical Properties of All-Weld Metal

	TS MPa(lbs/in <sup>2</sup> )	EL (%)	Temp °C(°F)	CVN-Impact Value J (ft-lbs)
100% CO <sub>2</sub>	640 (92,800)	40.8	-60 (-76)	53 (39.1)
80% Ar + 20% CO <sub>2</sub>	648 (93,960)	40.6	-60 (-76)	52 (38.3)

## Typical Welding Parameters

Diameter, Polarity Shielding Gas	CTWD mm (in)	Wire Feed Speed m/min (in/min)	Amp. (A)	Volt. (V)	Deposition Rate kg/hr (lb/hr)
1.2mm (0.045 in) DC+					
100% CO <sub>2</sub>	20 (4/5)	6.5 (256)	140	23-26	2.6 (5.7)
		9.2 (362)	180	27-30	3.7 (8.2)
		12.5 (492)	210	28-31	4.8 (10.6)
80% Ar + 20% CO <sub>2</sub>	20 (4/5)	6.2 (244)	140	23-26	2.7 (6.0)
		9.0 (354)	180	27-30	3.7 (8.2)
		12.0 (472)	210	27-30	4.9 (10.8)

Diam.	15 kg Spool
1.2mm	HKSW34712

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