FW 347

CODIFICATION:

AWS : SFA 5.9 ER347
EN ISO: 14343-A W (19 9 Nb)

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
%	0.04	1.4	0.37	0.010	0.015	19.15	9.5	0.55

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL:

UTS (MPa)	Elongation (L = 5d) %
580	33.0

SHIELDING GAS: Argon

CURRENT CONDITIONS: DCEN

WELDING POSITIONS: H, F, VU, OH

PACKING:

STANDARD SIZE: Diameter 1.6 mm, 2.0 mm, 2.4 mm & 3.2 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 each wire.