

TFW-347L

AWS A5.22 E347T1-1
EN ISO 17633-A-T 19 9 Nb P C1 1
JIS Z 3323 TS 347L-F C 1 1

Characteristics and Applications:

TFW-347L is designed for 100% CO₂ gas shielding and all-position welding wire. It exhibits excellent slag detachability and almost spatter-free operating features. It is used for joining stabilized stainless steels such as Types 321 and 347. It is also suitable for joining nonstabilized austenitic stainless steels such as Types 301, 302, 304, and CF-8.

Notes on usage:

1. Before welding, oil, rusty, and moisture should be cleaned off the base material that should have the proper protection from the wind in welding site.
2. Use 99.8% or higher purity CO₂ as shielding gas.
3. Keep the product dry, while it is stored or delivered.

Typical chemical composition of weld metal (wt%):

| C | Mn | Si | P | S | Cr | Ni | Nb |
|-------|------|------|-------|-------|-------|-------|------|
| 0.028 | 1.35 | 0.45 | 0.025 | 0.007 | 19.56 | 10.50 | 0.54 |

Typical mechanical properties of weld metal:

| Tensile strength MPa(ksi) | Elongation % |
|------------------------------|-----------------|
| 627(91) | 35 |

Welding position:



Sizes and recommended parameter range (DC<+>):

Stick out:15-20(mm),flow rate:20-25(l/min):

| Position | Diameter (mm) | 1.2 | 1.6 |
|----------|------------------|------------------|------------------|
| | F | 140-220A/ 23~33V | 200-300A/ 27~32V |
| HF | 140-220A/ 23~33V | 200-300A/ 27~32V | |
| VU、OH | 120-200A/ 24~30V | - | |

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