TFW-347L

AWS A5.22 E347T1-1
EN ISO 17633-A-T 19 9 Nb P C1 1
JIS Z 3323 TS347L-F C 1

Characteristics and Applications:

TFW-347L is designed for 100% CO_2 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 CO_2 as shielding gas.
3. Keep the product dry, while it is stored or delivered.

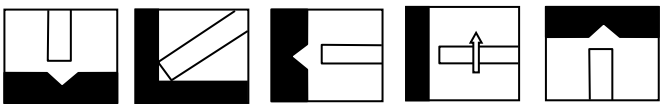
Typical chemical composition of weld metal (wt%):

	C	Mn	Si	P	S	Cr	Ni	Nb	Mo	Cu
AWS	≦ 0.08	0.5-2.5	≦ 1.0	≦ 0.04	≦ 0.03	18.0-21.0	9.0-11.0	8*C-1.0	≦ 0.75	≦ 0.75
EN ISO	≦ 0.08	≦2.0	≦ 1.2	≦ 0.030	≦ 0.025	18.0-21.0	9.0-11.0	8*C-1.1	≦ 0.3	≦ 0.5
Typical value	0.028	1.35	0.45	0.025	0.007	19.56	10.50	0.54	0.07	0.13

Typical mechanical properties of weld metal:

	Yield strength MPa(ksi)	Tensile strength MPa(ksi)	Elongation %
AWS	-	≧520(75)	≧30
EN ISO	≧350(51)	≧550(80)	≧25
Typical value	445(65)	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	150-220A/ 25~33V	200-300A/ 27~32V
HF	150-220A/ 25~33V	200-300A/ 27~32V
VU、OH	130-200A/ 24~30V	-

* The information contained or otherwise referenced herein is presented only as "typical" without guarantee or warranty, and TienTai Electrode Co., Ltd. expressly disclaims any liability incurred from any reliance thereon. Typical data is obtained when welded and tested in accordance with AWS specification. Other tests and procedures may produce different results. No data is to be construed as recommendation for any welding condition or technique not controlled by TienTai Electrode Co., Ltd.

FLUX CORED WIRES

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