

## AA 347H

**CATEGORY** FCAW Flux-Cored

**TYPE** Rutile fluxcored wire for welding stabilized stainless steel

**APPLICATIONS** For welding stainless austenitic steels that are exposed to working temperatures up to + 400°C.

**PROPERTIES** The weld deposit is scale-resistant up to approx. 800°C in normal atmosphere and oxidizing gases. The weld deposit is capable of taking a high polish. Structure: Austenite with delta ferrite. This fluxcored wire offers higher productivity, higher deposition rate and improved wetting properties due to slag support especially in positional welding. Excellent weldability and suitable for use with ceramic backing strips. Excellent weld metal quality and X-ray soundness.

**CLASSIFICATION**

AWS	A 5.22: E 347 T1-1/4
EN ISO	17633-A: T 19 9 Nb P C/M 2
DIN: W.Nr.	1.4551
DIN	8556: 19 9 Nb

**SUITABLE FOR**

1.4541	X 6 CrNiTi 18 10	1.4301	X 5 CrNi 18 10
1.4550	X 6 CrNiNb 18 10	1.4303	X 5 CrNi 18 12
1.4552	G-X 5 CrNiNb 18 9	1.4308	G-X 6 CrNi 18 9
1.4319	X 5 CrNi 18 7	1.4310	X 12 CrNi 17 7
1.4306	X 2 CrNi 19 11	1.4312	G-X 10 CrNi 18 8
1.4306	G-X 2 CrNi 18 9	-	-
-	-	-	-

Stainless steels for general use : NF A 35-573, 35-574, 35-575, 35-576 : Z6 CNT 18.10, Z6 CN Nb 18.10, Z2 CN 18.10, Z6 CN 18.09. :NS 21 C

**APPROVALS** CE approved

**WELDING POSITIONS:**



**WELD METAL WEIGHT %**

C	Mn	Si	Cr	Ni	Nb	FS	FN	FNW
0.03	1.30	0.60	18.7	10.4	0.6	6.7	7.3	6.3

FS: Schaeffler, FN: De Long, FNW: 1992 WRC

**TYPICAL ALL WELD METAL PROPERTIES**

Heat Treatment	R <sub>p0,2</sub> (N/mm <sup>2</sup> )	R <sub>m</sub> (N/mm <sup>2</sup> )	A <sub>5</sub> (%)	Impact Energy (J) ISO-V			Hardness HRC / HV
				+20°C	-40°C	-60°C	
AW	440	617	37	83			

AW: as welded

**WELDING PARAMETERS / PACKING**

Welding Parameters			Packing		
D (mm)	Voltage (V)	Current (A)	spool type	kg / spool	kg / pallet
1,2	23-30	150-220	KD-300	15	1080
1,6	25-33	180-280	KD-300	15	1080

**REDRYING TEMPERATURE** 150°C/24hr

**GAS ACCORDING EN 14175:** M21