

AA 347 TIG

CATEGORY FCAW Flux-Cored

TYPE Flux cored stainless steel welding wire for Tig welding

APPLICATIONS Boilers, shipbuilding, machinery, offshore application, foundries, chemical industry, root pass welding when backing gas is not available or preferred.

PROPERTIES These are all rutile flux cored TIG filler rods for root pass welding of stainless steel pipe without the need for a reverse side back purge (internal shielding gas). As they produce a slag, they are not recommended for multi-pass welding.

CLASSIFICATION
 AWS A 5.22: R 347T1-5
 EN ISO 1.4551
 DIN: W.Nr. 1.4551

SUITABLE FOR Suitable for 18%Cr-8%Ni+Ti or 18%Cr-8%Ni+Nb stabilized stainless steel.

APPROVALS CE approved

WELDING POSITIONS:



PURE WELD DEPOSIT

C	Mn	Si	Cr	Ni	Nb+Ta	S	P	FS	FN
0,02	1,60	0.80	19.0	10.2	0.7	0.004	0.021	9	13

MECHANICAL PROPERTIES

Heat treatment	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	Impact energy (J) ISO-V +20°C	Impact energy (J) ISO-V -40°C	Impact energy (J) ISO-V -120°C	Hardness HRc / HV
as welded	460	630	48	130			

WELDING PARAMETERS / PACKING

Parameters			Packing		
plate thickness (mm)	Root gab (mm)	Current DC-	diameter (mm)	kg	kg / master carton
3-5	2	80-90	2.2 x 1000	5	20
6-16	2.4	90-105			
>10	2.8	90-110			

REDRYING TEMPERATURE 150°C/24hr

GAS ACC. EN ISO 14175: I1