KISWEL K-347T

Classifications:

EN ISO 17633-A: 2008: T 19 9 Nb P C 1
EN ISO 17633-B: 2008: TS316L-FC1
AWS A5.22-07: E347T1-1

KS D 3612: YF-347C
JIS Z 3323: TS347-FC1

Typical Chemistry Composition of Weld Deposit:

C	Si	Mn	Cr	Ni	Nb
<0.08	<1.00	0.50 – 2.50	18.00 – 21.00	9.00 – 11.00	<1.00

Description:

- K-347T is formulated for MAG welding of 19%Cr-9%Ni-Nb stainless steels. (AISI 347, 321, ASTM A296; A157 Gr. C9; A320 Gr. B8C or D)
- Wire is a titania type of flux cored wire for all-position welding with low spatter generation, easy slag removal and good weld soundness.
- Nb content in Kiswel K-347T improves the resistance to intergranular and general corrosion of the weld metal.
- The said wire is available in Ferrite No. 5-12

Typical Mechanical Properties:

Yield Strength (Mpa)	Tensile Strength (Mpa)	Elongation (%)	Impact Value (J)
min. 350	Min. 550	min. 30	40 (-105°C)

Welding Parameters:

Wire Diameter	Shielding Gas	Current (A)		Voltage (V)	
		Min.	Max.	Min.	Max.
1.20 mm	CO_2	150	230	22	29

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