

# TFW-347

JIS Z 3323 TS347L-FC1  
AWS A5.22 E347T1-1  
EN 12073 T 19 9 Nb P C 2

## Characteristics and Applications:

TFW-347 is designed for 100% CO<sub>2</sub> gas shielding and all-position welding wire. It exhibits very 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, the base material should be cleaned from oil, rusty, moisture and the welding place should have the proper protection from the wind.
2. Use 99.8% or higher purity CO<sub>2</sub> as shielding gas. Maintain the flow rate no under than 20L/min when wire diameter is 1.2 or 1.6mm.
3. Trailer Shield is required to ensure the weld pool completely shielded until solidification is complete and no porosity problem.
4. Keep dry while in delivery and storage.

## Typical chemical composition of weld metal (wt%)

C	Mn	Si	P	S	Cr	Ni	Mo	Nb
0.03	1.48	0.54	0.029	0.009	19.56	9.72	0.10	0.54

## Typical mechanical properties of weld metal

TS (MPa) (kgf/mm <sup>2</sup> )	EL %	CVN -0°C J(kgf-m)
627(64)	35	50(5.1)

## Welding position



## Sizes and recommended current range (DC <+>)

Diameter (mm)	1.2		1.6	
	A	V	A	V
Welding condition				
F、HF	140-220	23-33	200-300	27-32
V-UP、OH	120-200	24-30	-	-

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