

**Classifications**

EN ISO 17633-A:2008	: T 19 9 Nb P C 1	KS D 3612	: YF-347LC
EN ISO 17633-B:2008	: TS347-FC1	JIS Z 3323	: TS347L-FC1
AWS A5.22-15	: E347T1-1		

**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 and it has low spatter generation, easy slag removal and good weld soundness.
- Nb component improves the resistance to intergranular corrosion of the weld metal.
- The weld metal contains optimum ferrite contents in their austenitic structures, Therefore their weldability is excellent with lower crack susceptibility.

**Welding positions****Polarity & shielding gas**

- CO<sub>2</sub>: 100% CO<sub>2</sub> (15~25ℓ/min)
- DCEP (DC+)

**Typical chemical composition of all-weld metal (%)**

Shielding gas	C	Si	Mn	Cr	Ni	Nb	FN
CO <sub>2</sub>	0.04	0.68	1.15	19.70	10.10	0.56	7.0

**Typical mechanical properties of all-weld metal**

	Y.S	T.S	El.	IV (J)		Remarks
	(MPa)	(MPa)		-60°C	-105°C	
AWS A5.22		min. 520	min. 30			
EN ISO 17633-B	min. 350	min. 520	min. 25			
Example	480	650	33	50	40	CO <sub>2</sub>

**Notes on usage and welding condition**

- Refer to page 303 for more information on usage
- When heat input is excessive, the impact value tends to be reduced. Therefore, perform welding with selecting proper heat input

**Package**

Dia. (mm)	0.9	1.2	1.6
Spool (kg)	5, 12.5, 15		