

Gas Metal Arc Welding

JIS Z3321 Y347L
AWS A5.9 ER347L
DIN -

MS M-347L Solid Wires for Stainless Steel

Applications Suitable for welding of 316,316L and 318 stainless steel. Low carbon content than MS M-347, with Nb(Cb) added as a stabilizer and reduces the possibility of intergranular chromium carbide precipitation

Brand Name		MS M-347L							
Representative of diameter (mm)	0.8	0.9	1.0	1.2	1.6	-	-	-	-
Chemical composition of wire (%)	C	Si	Mn	P	S	Ni	Cr	Mo	Nb
	≤ 0.030	≤ 0.65	1.0-2.5	≤ 0.03	≤ 0.03	9.0-11.0	19.0-21.5	-	10xc-1.0
Mechanical property of deposited metal									
Tensile strength	≥ 510 N/mm ²								
0.2% Offset strength	≥ 205 N/mm ²								
Elongation	≥ 30 %								
Impact test	NA								
Welding position	Horizontal/Flat position								
Welding polarity	DC-EP								
Shielding gas	98%Ar - 2%O ₂								
Welding current	Dia.0.8 mm	Dia.0.9 mm	Dia.1.0 mm	Dia.1.2 mm	Dia.1.6 mm				
	80-180A	120-200A	140-250 A	170-300 A	200-350A				
Packing	12.50 kgs standard other packing weight can be provided upon request.								