

# Gas Tungsten Arc Welding

JIS Z3321 Y347L  
 AWS A5.9 ER347L  
 DIN 8556-SG 1.4551

## MS T-347L Filler Rod for Stainless Steel

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

Brand Name		MS T-347L							
Representative of diameter (mm)	1.0	1.2	1.6	2.0	2.4	2.6	3.2	4.0	5.0
Representative of length	1000 mm Standard or 950 mm Upon requested								
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	≥ 500 N/mm <sup>2</sup>								
0.2% Offset strength	≥ 205 N/mm <sup>2</sup>								
Elongation	≥ 30 %								
Impact test	NA								
Welding position	All position								
Welding polarity	DC-EN								
Shielding gas	Ar								
Welding current	Dia. 1.2 mm		Dia. 1.6 mm			Dia. 2.4 mm			
	30-80 A		40-120 A			50-150 A			
Packing									
Inner case weight (kg)	5.00								