

## Shield-Bright 347H

Shield-Bright 347H was developed for the welding of stainless steel types 321 and 347 where a minimum of 0.04% carbon is required. As with all 347 weld metals, for service at temperatures greater than 1000(550) it can be used in circumstances of lower stress and advisedly under creep conditions. Shield-Bright 347H can also be used for the welding of types 302 and 304 stainless steels. Shield-Bright 347H was developed for welding in all positions and performs particularly well in the vertical position with excellent slag removal.

### Specifications

<b>Classifications</b>	JIS Z3323 : TS347-FB1 AWS A5.22 : E347T1-1(4)
<b>Approvals</b>	JIS

Approvals are based on factory location. Please contact ESAB for more information.

### Typical Tensile Properties

Yield Strength	Tensile Strength	Elongation
<b>100% CO<sub>2</sub></b>		
450 MPa ( 65 ksi )	650 MPa ( 94 ksi )	40 %
<b>75% Ar - 25% CO<sub>2</sub></b>		
520 MPa ( 75 ksi )	650 MPa ( 94 ksi )	35 %

### Typical Weld Metal Analysis %

C	Mn	Si	S	P	Ni	Cr	Nb	Ferrite FN
<b>75% Ar - 25% CO<sub>2</sub></b>								
0.060	1.10	0.85	0.010	0.020	9.7	19.5	0.60	3-8
<b>100% CO<sub>2</sub></b>								
0.060	1.00	0.50	0.010	0.020	9.8	18.5	0.55	3-8