

Exaton 347 T1

FCAW wire for 18%Cr - 8%Ni – Nb stainless steel For all-position welding. Developed to weld types 347, 304, 304L and 321 stainless, where service temperatures are below 316. The addition of columbium helps minimize chromium carbide precipitation while providing improved corrosion resistance.

Specifications

Classifications	SFA/AWS A5.22 : E347T1-1 SFA/AWS A5.22 : E347T1-4 JIS Z 3323 : TS347-FB1 KS D 3612 : YF347C EN ISO 17633-A : T 19 9 Nb P M21 2
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Welding Current	DC+
Alloy Type	C Cr Ni
Shielding Gas	M21, C1 (EN ISO 14175)

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
C1 Shielding Gas			
As Welded	430 MPa (62 ksi)	620 MPa (90 ksi)	45 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
C1 Shielding Gas		
As Welded	-196 °C (-321 °F)	29 J (21 ft-lb)
As Welded	-29 °C (-20 °F)	55 J (41 ft-lb)
C1 Shielding gas		
As Welded	-196 °C (-321 °F)	29 J (21 ft-lb)
As Welded	-29 °C (-20 °F)	55 J (41 ft-lb)

Typical Weld Metal Analysis %

C	Mn	Si	S	P	Ni	Cr	Cu
C1 Shielding Gas							
0.04	1.10	0.80	0.01	0.02	9.95	19.0	0.15

Deposition Data

Diameter	Current	Voltage	Wire Feed Speed	Deposition Rate
1.2 mm (0.045 in.)	130-220 A	24-29 V	5.8-14.4 m/min (228-567 in./min)	1.9-4.6 kg/h (4.2-10. lbs/h)