

Shield-Bright 347

FCAW wire for 18%Cr - 8%Ni – Nb stainless steel. For all-position welding. Developed to weld types 347, 304, 304L and 321 stainless. The addition of Niobium 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 C1 2 EN ISO 17633-A : T 19 9 Nb P M21 2
Approvals	DNV-GL : VL 347 (C1) NAKS/HAKC : 1.2mm

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

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	620 MPa	45 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
C1 Shielding Gas		
As Welded	-29 °C	55 J
As Welded	-196 °C	29 J

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	130-220 A	24-29 V	5.8-14.4 m/min	1.9-4.6 kg/h