

FLUXINOX 347

Cored Wires Stainless and Heat resistant steels

Fluxinox 347 is an alloyed rutile flux cored wire for the welding of stabilized corrosion resistant Cr Ni-steels. The weld metal is used for operating temperatures up to 400 °C, non-scaling up to about 800 °C. Fluxinox 347 exhibits excellent, almost spatter-free, welding properties with very easy slag removal from fillet welds. The weld beads produced are flat and smooth without undercut and with little discoloration of the weld, thus pickling costs can be minimised.

Classification	
AWS	A5.22: E347T0-4 / E347T0-1
EN	12073: T 19 9 Nb R M 3 / T 19 9 Nb R C 3

Approvals	Grades
TÜV	
UDT	

see Appendix, Classification Society Approvals, for details pag. 521

Analysis of all-weld metal (Typical values in %)

C	Mn	Si	P	S	Cr	Ni	Mo	Nb	Cu	N	Ferrite
≤ 0.04	1.50	0.90	-	-	20	10	-	0.40	-	-	5-10

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation A5 (%)	Impact Energy ISO - V (J) - 196 °C	Hardness
As Welded	≥ 350	≥ 550	≥ 30	≥ 32	-


Gas test: Acc. To EN 439: M21(Arcal 21-Atal 6)

Shielding Gas: Acc. To EN 439: M21(Arcal21-Atal6) or C1(Arcal 2)

Materials

1.4541 (X6CrNiTi18-10); 1.4301 (X4CrNi18-10); 1.4550 (X6CrNiNb18-10);
 AISI 347 - 321

Storage
Keep dry and avoid condensation

Current condition and welding position
DC+

PA PB PC

Packaging data: K300 kg. 16

Diameters	1,0	1,2			