

Cored Wires Stainless and Heat resistant steels

Fluxinox 347-PF is an alloyed rutile flux cored wire with a fast-freezing slag for the welding of stabilized corrosion resistant Cr Ni-steel. The weld metal is suitable for operating temperatures up to 400°C, non-scaling up to about 800°C. Fluxinox 347-PF exhibits outstanding, easy slag removal from fillet welds, even in acute angles. Welds produced are flat and smooth without undercut and due to only slight discoloration of the welds, pickling costs can be minimised. Owing to the fast-freezing slag, Fluxinox 347 PF is used for welding in the horizontal (PD), overhead (PE) and vertical-up (PF) positions.

Classification	
AWS	A5.22: E347T1-4 / E347T1-1
EN	12073: T 19 9 Nb P M 1 / T 19 9 Nb P C 1

Approvals	Grades
TÜV	

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+



Packaging data: K300 kg. 16

Diameters	1,0	1,2			
-----------	-----	-----	--	--	--