

AST 347 is an agglomerated submerged-arc welding flux used with austenitic stabilized stainless steel strips, such as Suprastrip 347.

The special formula enhances the weld bead profile with excellent and easy slag detachability. The flux is suitable for weld overlay in petrochemical, chemical and nuclear applications.

Damp flux should be re-dried at 300-350°C. Grain size according to EN 760: 2-20.

Wire	Classification
	DIN 32522: B AB 6 8235 DC+ 15 B-3
	EN 760: SA AB 2

Wire	Approvals	Grades

Flux Analysis	
MgO	14 %
CaF ₂	13 %
CaF ₂	4 %
Al ₂ O ₃	24 %
SiO ₂	35 %

Basicity to Boniszewski 0,8

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

Wire	C	Mn	Si	Cr	Ni	Mo	Nb	N	Cu
SUPRASTRIP 347 3rd Layer	0.045	1	0.90	19	10	-	0.50	-	-

Packaging data

Metallic drum 30kg

Further forms of delivery on request.

Current condition

DC+