

EXECUTIVE 347

STAINLESS STEEL

FLUX CORED WIRE TECHNICAL DATA SHEET

DESCRIPTION

Executive 347 provides superior weldability, low spatter and smooth beads with easy slag removal. Addition of columbium as carbon stabilizer.

Usually used for welding chromium-nickel stainless steel base metals of similar composition stabilized with either Nb or Ti. Although Nb is the stabilizing element usually specified in Type 347 alloys, it should be recognized that tantalum (Ta) is also present. Ta and Nb are almost equally effective in stabilizing carbon and in providing high-temperature strength. If dilution by the base metal produces a low ferrite or fully austenitic weld metal, the crack sensitivity of the weld may increase substantially

APPLICATIONS & FEATURES

Used for welding of 18% Cr-8% Ni-Ti and 18% Cr-8% Ni-Cb because of its excellent creep-rupture property at high temperature.

TYPICAL WIRE CHEMISTRY & MECHANICAL PROPERTIES												
С	Cr	Ni	Мо	Mn	Si	Р	S	Cb	N			
0.05	19.16	9.68	0.55	1.64	0.39	0.021	0.01	0.63	0.012			
Tensile Strength: Yield Strength:		81,400 PSI min 62,269 PSI min						Elongat	ion:	37%		

TYPICAL WELDING PARAMETERS

Diameter	Voltage	Amperage	WFS (in/min)	Shielding Gas*
.045"	24	130	225	
.045"	27	175	320	100% CO2 or Ar + 20-25% CO2
.045"	30	240	530	
.062"	27	195	152	
.062"	31	260	260	100% CO2 or Ar + 20-25% CO2
.062"	34	320	360	

*Shielding gas flow rate 35 to 50 CFH. For 100% CO_2 use two volts higher than shown

STANDARD PACKAGING

FCAW

33-lb plastic spools

1,980-lb pallet



CLASSIFICATION

AWS/SFA 5.22, Class E347T0-1/4