SUPERCORE 347

FCAW

DOWNHAND RUTILE FLUX CORED WIRE FOR 321/347

PRODUCT DESCRIPTION

Flux cored wire made with an austenitic stainless steel sheath and rutile flux system. Supercore 347 combines easy operability, high deposit quality and good weld bead appearance for downhand and HV welding. Metal recovery is about 90% with respect to wire.

CLASSIFICATIONS

AWS A5.22M	E347T0-1/4
ISO 17633-A	T19 9 Nb R C/M 3
ISO 17633-B	TS347-F C1/M21 0

ASME IX QUALIFICATION

QW432	F-No 6
QW442	A-No 8

CHEMICAL COMPOSITION (WELD METAL WT %)

	C	Mn	Si	S	P	Cr	Ni	Mo	Nb	Cu	FN
Min.	--	0.5	--	--	--	18.0	9.0	--	8xC	--	4
Max.	0.08	2.0	1.0	0.025	0.030	21.0	11.0	0.3	1.0	0.3	12
Typical	0.03	1.2	0.4	0.01	0.02	19	10.5	0.1	0.5	0.1	8

ALL-WELD MECHANICAL PROPERTIES

As welded	**Min.**	**Typical**
Tensile strength (MPa)	550	600
0.2% proof strength (MPa)	350	435
Elongation (%) 4d	30	47
5d	25	42
Reduction of area %	--	50
Impact ISO-V(J) +20°C	--	90

OPERATING PARAMETERS

Shielding gas: 80%Ar-20%CO_2 at 20-25l/min. Proprietary gases may be used but argon should not exceed 85% argon. The wire is suitable for use on CO_2 but with some loss of cosmetic appearance and increased spatter.

Current: DC+ve ranges as below (for 100%CO_2 increase voltage by 2-3V):

Diameter (mm)	**amp-volt range**	**typical**	**stickout**
1.2	120 – 280A, 22 – 34V	180A, 29V	15 – 20mm

PACKAGING DATA

Diameter (mm)	**Weight (kg)**	**Packaging**	**Item number**
1.2	15	S300	SC347-12

FUME DATA (WT % TYPICAL)

Fe	**Mn**	**Ni**	**Cr^3**	**Cr^6**	**Cu**	**F**	**OES (mg/m^3)**
17	11	2	4	5	<1	5	1