

# TFW-347L

AWS A5.22 E347T1-1  
EN ISO 17633-A-T 19 9 Nb P C1 1  
JIS Z 3323 TS347L-F C 1

## Characteristics and Applications:

TFW-347L is designed for 100% CO<sub>2</sub> gas shielding and all-position welding wire. It exhibits excellent slag detachability and almost spatter-free operating features. It is used for joining stabilized stainless steels such as Types 321 and 347. It is also suitable for joining nonstabilized austenitic stainless steels such as Types 301, 302, 304, and CF-8.

## Notes on usage:

1. Before welding, oil, rusty, and moisture should be cleaned off the base material that should have the proper protection from the wind in welding site.
2. Use 99.8% or higher purity CO<sub>2</sub> as shielding gas.
3. Keep the product dry, while it is stored or delivered.

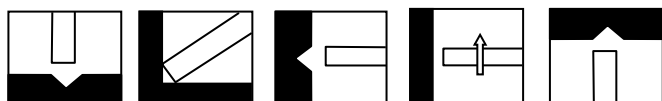
## Typical chemical composition of weld metal (wt%):

	C	Mn	Si	P	S	Cr	Ni	Nb	Mo	Cu
AWS	≤ 0.08	0.5-2.5	≤ 1.0	≤ 0.04	≤ 0.03	18.0-21.0	9.0-11.0	8*C-1.0	≤ 0.75	≤ 0.75
EN ISO	≤ 0.08	≤ 2.0	≤ 1.2	≤ 0.030	≤ 0.025	18.0-21.0	9.0-11.0	8*C-1.1	≤ 0.3	≤ 0.5
Typical value	0.028	1.35	0.45	0.025	0.007	19.56	10.50	0.54	0.07	0.13

## Typical mechanical properties of weld metal:

	Yield strength MPa(ksi)	Tensile strength MPa(ksi)	Elongation %
AWS	-	≥ 520(75)	≥ 30
EN ISO	≥ 350(51)	≥ 550(80)	≥ 25
Typical value	445(65)	627(91)	35

## Welding position:



## Sizes and recommended parameter range (DC <+>):

Stick out:15-20(mm),flow rate:20-25(l/min):

Position	Diameter (mm)	1.2	1.6
	F		150-240A/ 25~32V
HF		150-240A/ 25~32V	180-300A/ 27~35V
VU、OH		130-200A/ 24~28V	-

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