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WT-347

AWS A5.22 E347T1-1/4

JIS Z3313 YF347C

KS D3612 YF347C

FOR STAINLESS
STEEL

Applications

WT-347 is formulated for MAG welding of 18%Cr-8%Ni-Nb stainless steels.

(AISI 347, 321, ASTM A296; A157 Gr. C9; A320 Gr. B8C or D)

Characteristics on Usage

- 1) This is a rutile type flux cored wire for all-position welding.
- 2) Wire has low spatter, easy slag removal and good weld soundness.
- 3) Nb component improves the resistance to intergranular corrosion of the weld metal.

Notes on Usage

- 1) Use 100% CO₂ gas or Ar+20~25% CO₂ gas.
- 2) The optimum flow of CO₂ for shielding is 20~25ℓ/min.
- 3) Protect the weld with a screen to prevent blowholes caused by wind where the wind velocity is 2m/sec and more.
- 4) Keep the distance between tip & base metal at 15~25mm.
- 5) For multi layer welding, keep preheat and inter-pass temperature below 150°C.

Typical chemical composition of all-weld-metal (%) (Shielding gas : CO₂)

	chemical composition(%)							
	C	Si	Mn	P	S	Cr	Ni	Cb(Nb)
AWS	≤0.08	≤1.0	0.5~2.5	≤0.04	≤0.03	18~21	9~11	8xC~1.0
WT-347	0.03	0.6	1.26	0.02	0.07	19.3	10.1	0.4

Typical mechanical properties of all-weld-metal (Shielding gas : CO₂)

	Tensile strength (N/mm ²)	Elongation %	Impact value (J)	
			0°C	-18°C
AWS	≥520	≥30	-	-
WT-347	586	41	-	60

Size available and recommend welding parameters (DC+)

Position		Dia	1.2(.045)	1.6(1/16)
			Current(A)	
Flat			180~220	200~280
Horizontal Fillet			180~220	200~280
Vertical up			120~160	160~220

Welding positions



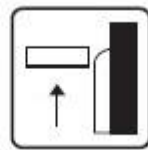
1G



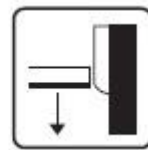
2F



3G



V-UP



V-DOWN



4G