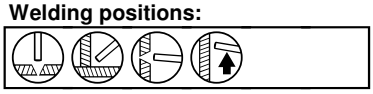
Cromacore DW 347

FCAW - Flux cored arc welding
Stainless Steel

Date:	2010-10-22
Revision:	6

Description:
Cromacore DW 347 is a rutile flux cored wire for welding the Nb or Ti stabilised stainless steel grades 347 and 321. It is also suitable for the unstabilised grades 304 and 304L. For welding the controlled carbon material grades 321H and 347 H, used for structural applications at temperatures above 400°C, Cromacore DW 308H is recommended because of its superior creep strength. The wire is mainly used for the horizontal and horizontal-vertical positions.
Cromacore DW 347 is BIsmuth free (<0,002 wt%).

Welding positions:



Welding current:
DC +

Deposition efficiency:
87%

Shielding gas:
M21, 80% Ar + 20% CO_2, 22-25 l/min.
100% CO_2, 22-25 l/min.

Stick-out:
15-25 mm

Ferrite content:
FN 5

Chemical composition, wt.%

	C	Si	Mn	P	S	Cr	Ni
Min			0.5			18.0	9.0
Typical	0.03	0.4	1.1	0.025	0.006	18.5	9.5
Max	0.08	1.0	2.0	0.030	0.025	21.0	11.0

	Mo	Cu	V	Cb[1]
Min				8xC
Typical	0.1	0.01	0.1	0.7
Max	0.5	0.5	0.2	1.0

[1] Cb (Nb) + Ta

Mechanical properties

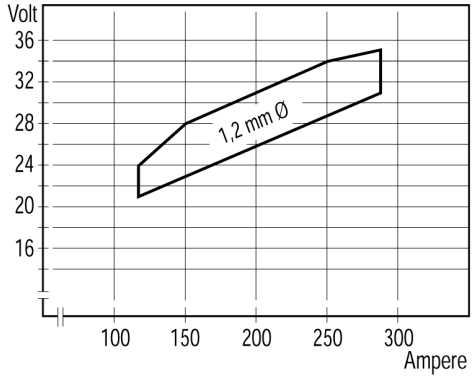
	Specified	Typical
Yield strength, Rp0.2%:		415 MPa
Tensile Strength, Rm:	≥ 550 MPa	590 MPa
Elongation, A5	≥ 30%	43
Impact energy, CV:		0°C • 49 J

Classification:

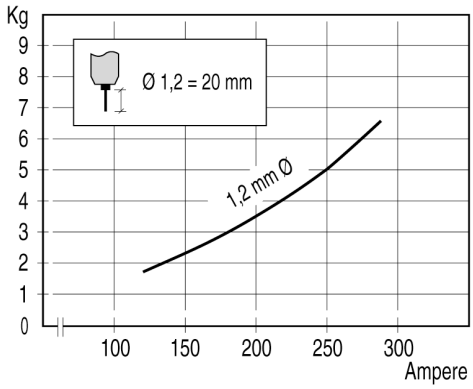
AWS A5.22	E347T0-4/-1
ISO 17633-A	T 19 9 Nb R M/C 3

Approvals:

Recommended parameter range:



Deposition rate per hour:



Product data:

Diam.mm	Product code	Spool weight
1,2	95791012	15 kg BS300

Note

For elevated temperatures service.
Ferrite content: Acc. to WRC-92
Strip:
S ≤ 0.03%
P ≤ 0.04%
N ≤ 0.06%