



MIGINOX FC 347

FCAW STAINLESS STEEL

AWS A/SFA 5.22 E347T1-1/4

CLASSIFICATION:

EN ISO 17633-A

T 19 9 Nb P C1 2

T 19 9 Nb P M21 2

KEY FEATURES:

- Rutile based gas shielded stainless steel FCW wire
- Typical 19/9/Nb stabilized stainless steel deposit
- Stable arc, low spatter and easy slag removal
- Excellent bead appearance
- Resistance to cracking and embrittlement
- Resistance to intergranular corrosion and scaling up to 850°C
- Radiographic weld quality

APPROVALS: CE

TYPICAL APPLICATIONS:

- Welding stabilized Cr-Ni steels such as AISI 321, 321H, 347, 347H
- Welding of stainless steel tanks, valves, pipes in food, chemical and petrochemical industries
- Fabrication of boiler and gas turbine
- Fabrication of equipments in refineries, power plants, centrifugal pump impellers and shafts, valve faces, seats

CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:


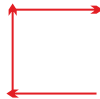
C	Mn	Si	Cr	Ni	Mo	Nb+Ta	Cu
0.08 max	0.50-2.50	1.0 max	18.0-21.0	9.0-11.0	0.75 max	8xC-1.0	0.75 max

MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	EL%
Specification	As Welded	520 min	30 min

With mixed gas chemical composition and mechanical properties will be higher.

PARAMETERS - PACKING DATA:

Ø, mm	Kg/Spool	
1.2	12.5	 DCEP All Positions, Except Vertical Down:  STORAGE / HANDLING : Keep dry and follow handling instructions mentioned on the box
1.6	12.5	

Shielding Gas	Gas Flow Rate, LPM
CO ₂	15-20
80Ar+20CO ₂	18-25