



FCAW STAINLESS STEEL
MIGINOX FC 347

Nb STABILIZED STAINLESS STEEL GAS SHIELDED FLUX CORED WIRE



CLASSIFICATION : AWS A/SFA 5.22 EN ISO 17633-A

E347T1-1/4

T 19 9 Nb R C/M 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

WELDING POSITION :



DCEP

Shielding Gas	Gas Flow Rate, LPM	Stickout, mm
CO ₂	10-20	10-20
80Ar+20CO ₂	18-25	10-20

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

STORAGE / HANDLING :

Keep dry and follow handling instructions mentioned on the box

CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt% :

	C	Mn	Si	Cr	Ni
Specification	0.08 max	0.50-2.50	1.0 max	18.0-21.0	9.0-11.0
	Mo	Nb+Ta	Cu	S	P
Specification	0.75 max	8xC-1.0	0.75 max	0.03 max	0.04 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	Voltage, V	Amperage, A	Kg/Spool
1.2	22 - 32	120 - 300	12.5
1.6	24 - 34	200 - 360	12.5

EQUIVALENT :

SMAW Electrode: **Superinox 1B**

GMAW Wire: **Miginox 347**

GTAW Wire: **Tiginox 347**