

## ❖ Product Description

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|--|---|
| I. Gas shielded, rutile type FCW wire                    | V. Uniform and good weld bead appearance                    |
| II. Low fumes, very less spatter and slag removed easily | VI. Typical 19/9/Nb stabilized stainless steel weld deposit |
| III. Resistance to cracking and embrittlement            | VII. Radiographic weld quality                              |
| IV. Resistance to intergranular corrosion and scaling    |   |

## ❖ Range of Application

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|--|--|
| I. Extremely good for welding of stabilized steels such as AISI 321, 321H, 347, 347H       | III. Fabrication in boiler and gas turbine   |
| II. In stainless steel tanks, valves, pipes in food, chemical and petrochemical industries | IV. For use in refineries, power plants, centrifugal pump impellers and shafts, valve faces, seats |

## ❖ Classification

- AWS/SFA 5.22 E347T1

## ❖ % Chemical Composition

Type of Wire		C	Mn	Si	S	P	Mo	Nb+Ta	Ni	Cu
E347T1	Min	-	0.50	-	-	-	-	8XC	9.0	-
	Max	0.08	2.50	1.0	0.03	0.04	0.75	1.0	11.0	0.75

## ❖ Mechanical Properties of all weld metal

Condition	UTS, MPa (Min)	YS, MPa (Min)	% Elongation	Charphy "v" Notch Impact @ -30°C
PWHT	520	-	30	-

## ❖ Wire Size & Welding Position

- Diameter in mm- 1.2, 1.6
- Weld Position- All position

## ❖ Current & Gas Flow

- DCEP; 18-25lit/min

## ❖ Packaging

- Standard packaging in 15kg Spool form

### Special Notes: -

- (1) All the value above mentioned are typical values.
- (2) Usually all chemistry and mechanical properties will depend on actual wire chemistry and arc voltage used for welding.

### **SHAKUNT ENTERPRISES PRIVATE LIMITED**

**Corporate Office:** - 619/A, EMMAR DIGITAL GREEN, 6th Floor, Sector-61, GURUGRAM (HARYANA)-122102  
E-Mail:- [info@shakunt.com](mailto:info@shakunt.com)

**Ludhiana Works:-** B-XXIX-595/5,Campa Cola Road,Dhandari Kalan Industrial Area-C,Ludhiana (PUNJAB) INDIA

**Dharwad Works:-** Plot no.577 C & D,Belur Industrial Area,Dharwad-580011 (KARNATAKA) INDIA

**Vadodara Works:-** 67-A,G.I.D.C,Majusar,Savli,Vadodara-397115 (GUJARAT) INDIA