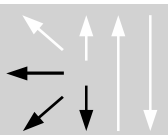


Classifications							
<b>EN ISO 17633-A</b>		<b>EN ISO 17633-B</b>			<b>AWS A5.22</b>		
T 19 9 Nb R M21/C1 3		TS 347L-F M21/C1 0			E347T0-4/1		
Characteristics and typical fields of application							
<p>Rutile strip-alloyed flux-cored wire of T 19 9 Nb R / E347LT0 type for welding of stainless steels such as EN 1.4546 / AISI 347. Designed for single and multi-pass welding mainly in the flat and horizontal position, horizontal/vertical position as well as the slightly vertical-down position. Primarily intended for high temperature service or applications that should be heat treated. The corrosion resistance corresponds to that of 308H, i.e. good resistance to general corrosion. Easy handling and high deposition rate result in high productivity with excellent welding performance and very low spatter formation. Increased travel speeds as well as self-releasing slag with little demand for cleaning and pickling provide considerable savings in time and money. The wire shows good wetting behavior and results in a finely rippled surface pattern. The wide arc ensures even penetration and side-wall fusion to prevent lack of fusion. Stabilized with niobium and suitable for service temperatures from <math>-196^{\circ}\text{C}</math> to <math>400^{\circ}\text{C}</math>. For welding in vertical-up and overhead positions, BÖHLER SAS 2 PW-FD should be preferred.</p>							
Base materials							
<p>EN 1.4301 X5CrNi18-10, 1.4306 X2CrNi19-11, 1.4311 X2CrNi18-9, 1.4312 GX10CrNi18-8, 1.4541 X6CrNiTi18-10, 1.4546 X5CrNiNb18-10, 1.4550 X6CrNiNb18-10, 1.4552 GX5CrNiNb19-11            UNS S30400, S30403, S30453, S32100, S34700            AISI 347, 321,302, 304, 304L, 304LN; ASTM A296 Gr. CF 8 C, A157 Gr. C9, A320 Gr. B8C or D</p>							
Typical analysis of all-weld metal							Ferrite WRC-92
	C	Si	Mn	Cr	Ni	Nb	FN
wt.-%	0.03	0.6	1.4	19.5	10.6	0.035	5 – 13
Mechanical properties of all-weld metal – typical values (minimum values)							
Condition	Yield strength $R_{p0.2}$	Tensile strength $R_m$	Elongation A ( $L_0=5d_0$ )	Impact work ISO-V KV J			
	MPa	MPa	%	20°C	$-120^{\circ}\text{C}$	$-196^{\circ}\text{C}$	
u	<b>420</b> ( $\geq 350$ )	<b>585</b> ( $\geq 550$ )	<b>40</b> ( $\geq 30$ )	<b>80</b>	<b>41</b>	<b>32</b> ( $\geq 32$ )	
u untreated, as-welded – shielding gas Ar + 18 % CO <sub>2</sub>							
Operating data							
	Ø (mm)	Wire feed m/min	Arc length mm	Current A	Voltage V		
	1.2	5.0 – 15.0	~ 3	130 – 230	22 – 30		
	1.6	4.5 – 9.5	~ 3	200 – 350	25 – 30		
<p>Welding with standard GMAW power source with DC+ polarity. No pulsing needed. Backhand (drag) technique preferred with a work angle of appr. <math>80^{\circ}</math>. Ar + 15 – 25 % CO<sub>2</sub> as shielding gas offers the best weldability. 100 % CO<sub>2</sub> can be also used, but the voltage should be increased by 2 V. The gas flow should be 15 – 18 l/min. The heat input should not exceed 2.0 kJ/mm, the interpass temperature be limited to max. <math>150^{\circ}\text{C}</math> and the wire stick-out 15 – 20 mm. Re-drying of the wire possible at <math>150^{\circ}\text{C}</math> for 24 h if necessary. The scaling temperature is approx. <math>850^{\circ}\text{C}</math> in air. Post-weld heat treatment generally not needed.</p>							
Approvals							
TÜV (09740.), CE							