



# WB6347 FLUX CORED WELDING WIRE

<b>Classifications</b>	AWS A5.22-95 : E347TO-4									
<b>Product Description</b>	Rutile, stainless steel, formed, flux cored, welding wire. Fully positional.									
<b>Applications</b>	<p>WB6347 is suitable for the repair and welding of 304, 321 and 327 Niobium stabilised stainless steels to give freedom from intergranular attack.</p> <p>Typical grades include:- wrought BS321S31, 347S31, BSEN 1.4541, 1.4550, ASTM/ASME 321, 347, DIN 1.4541, 1,4543, 1.4546, 1,4550. Cast 347C17, CF8C and 1.4552.</p> <p>Ferrite in the 3-8 FN range.</p>									
<b>Wire Composition (Weight%)</b>	C	Mn	Si	S	P	Cr	Ni	Mo	Cu	Nb
<b>min.</b>	-	1.0	0.30	-	-	19.0	9.0	-	-	10xC
<b>max.</b>	0.08	2.5	0.65	0.03	0.03	21.5	11.0	0.5	0.50	1.0
<b>Typical All-Weld Metal Mechanical Properties</b>	Ultimate Tensile Strength		N/mm <sup>2</sup>		550 min.					
	Yield Stress/0.2% Proof Stress		N/mm <sup>2</sup>		350 min.					
	Elongation on 5D		%		25 min.					
	Impact Energy CV @ as-welded		Joules		-					

<b>Wire Dia (mm)</b>		0.6mm	0.8mm	0.9mm	1.2mm	1.6mm	2.4mm	3.2mm
<b>Current Range (Amps)</b>	<b>min.</b>	-	-	80	120	200	-	-
	<b>max.</b>	-	-	160	280	330	-	-
<b>Volt Range (Volts)</b>	<b>min.</b>	-	-	22	22	26	-	-
	<b>max.</b>	-	-	32	34	36	-	-
<b>Packaging Information</b>								
<b>Kg Per Reel</b>		-	-	12.5	12.5	12.5	-	-
<b>Storage</b>	<b>Storage</b> It is recommended that the WB range of wires are stored in a dry heated store at a minimum temperature of 18°C, and a maximum relative humidity of 60%.							
<b>Gases</b>	<b>Gas</b> 80% Argon 20% CO <sub>2</sub> mixture  <b>Flow Rate</b> 12-16 l/min							

## Current Conditions DC+ and Welding Positions

