



WB6347P FLUX CORED WELDING WIRE

Classifications	AWS A5.22-95 : E347T1-4									
Product Description	Rutile, stainless steel, formed, flux cored, welding wire. Fully positional.									
Applications	<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>									
Wire Composition (Weight%)	C	Mn	Si	S	P	Cr	Ni	Mo	Cu	Nb
min.	-	1.0	0.30	-	-	19.0	9.0	-	-	10xC
max.	0.08	2.5	0.65	0.03	0.03	21.5	11.0	0.5	0.50	1.0
Typical All-Weld Metal Mechanical Properties	Ultimate Tensile Strength		N/mm ²		550 min.					
	Yield Stress/0.2% Proof Stress		N/mm ²		350 min.					
	Elongation on 5D		%		25 min.					
	Impact Energy CV @ as-welded		Joules		-					

Wire Dia (mm)		0.6mm	0.8mm	0.9mm	1.2mm	1.6mm	2.4mm	3.2mm
Current Range (Amps)	min.	-	-	80	120	200	-	-
	max.	-	-	160	280	330	-	-
Volt Range (Volts)	min.	-	-	22	22	26	-	-
	max.	-	-	32	34	36	-	-
Packaging Information								
Kg Per Reel		-	-	15	15	15	-	-
Storage	Storage 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%.							
Gases	Gas 80% Argon 20% CO ₂ mixture Flow Rate 12-16 l/min							

Current Conditions DC+ and Welding Positions

