WB6347P FLUX CORED WELDING WIRE

Classifications	**AWS A5.22:** E347T1-1/4 **BS EN ISO 17633-A:** T 19 9 Nb P M 1
Product Description	Rutile, stainless steel, formed, flux cored, welding wire. Fully positional.
Applications	WB6347 is suitable for the repair and welding of 304, 321 and 327 Niobium stabilised stainless steels to give freedom from intergranular attack. 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. Ferrite in the 3-8 FN range.

Wire Composition (Wt.%)

	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/mm²	550 min.
Yield Stress/0.2% Proof Stress	N/mm²	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.**	-	-	100	150	200	-	-
	max.	-	-	200	300	380	-	-
Volt Range (Volts)	**min.**	-	-	17	18	22	-	-
	max.	-	-	28	30	32	-	-
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** 15-20 l/min

Current Conditions DC+ and Welding Positions

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