



WB6347 FLUX CORED WELDING WIRE

Classifications	AWS A5.22: E347T0-1/4 BS EN ISO 17633-A: T 19 9 Nb R M 3										
Product Description	Rutile, stainless steel, formed, flux cored, welding wire. Specially designed for use in the downhand position.										
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 (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/mm ²		550 min.						
	Yield Stress/0.2% Proof Stress		N/mm ²		350 min.						
	Elongation on 5D		%		25 min.						
	Impact Energy CV @		Joules		-						
	As welded										

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

