

AK E347LT1-1

Description: E347T1-1 is a stainless steel gas shielded flux-cored wire designed for all positional welding, can be used to weld 347 and 321 stainless steel. The weld deposit has 5-15% ferrite. Niobium (Nb) is used as the stabilized element to prevent intergranular corrosion.

Application: Used to weld important anti-corrosion steel which contains Nb or nickel-chrome alloys which Ti as the stabilized element.

Typical Chemical Composition(%):

	C	Si	Mn	S	P	Ni	Cr	Mo	Cu
Requirement	0.08	1.00	0.50-2.50	0.03	0.04	9.0-11.0	18.0-21.0	0.50	0.50
Actual Result	0.05	0.60	1.60	0.01	0.01	10.0	20.0	0.01	0.03

Typical Mechanical Properties:

	Tensile Strength (MPa)	Yield Stress (MPa)	Elongation (%)	Impact values (J)
Requirement	≥ 520	—	≥ 30	—
Actual Result	550	—	35	—

Recommended welding parameters:

Diameter/ mm	1.2	1.6		
Welding voltage/V	22-36	26-38	—	—
Welding current/A	120-260	200-300	—	—