

GFC 347

FLUXCORED WIRE FOR STAINLESS STEEL

IDENTIFICATION

GFC 347, E347T1-1/4

CLASSIFICATION

AWS/SFA 5.22:E347T1-1/4

DESCRIPTION

- Rutile gas shielded stainless steel wire for down hand welding.
- Excellent resistance in oxidizing environments such as nitric acid.
- High resistance to intergranular corrosion.
- Easy slag release and smooth bead appearance.

WELD METAL ANALYSIS (RANGE) %

C	Mn	Si	S	Cr	Ni	Nb	P
0.080 max	1.68 max	0.49 max	0.030 max	18.0 - 21.5	09-Nov	8 x C or 1.0 max	0.030 max

MECHANICAL PROPERTIES (RANGE)

UTS (MPa)	EL (%) (L=4D)	CVN Impact Value	
		Temp	Joules
520 min	30 min	0°C	60 - 90

TYPICAL APPLICATIONS

- Weld metal 19.5% Cr - 10% Ni - Nb which adds Nb in order to reduce carbide precipitation.
- It is suitable for welding AISI 347, 321, 304L and 302 stainless steel.

WELDING INSTRUCTION

- Dilution of base metal produces ferrite or pure austenitic to increase crack susceptibility.

SHIELDING GAS : CO₂ or (80% Ar + 20% CO₂ mix gas)

WELDING POSITION : Down hand

PACKING PARAMETERS

Size (mm)	Fillet (HF)		Voltage (OH)		Weight / Spool (kg)
	AMPS DC (+)	VOLTAGE (V)	AMPS DC (+)	VOLTAGE (V)	
1.2	100 - 300	20 - 36	100 - 200	24 - 30	12.5
1.6	200 - 360	26 - 40	Not Recommended		12.5