

TASETO Welding Materials

Bare Stainless Steel Rods

For Gas Tungsten Arc Welding

TG347

● Applicable Specification

JIS Z 3321 YS347
AWS A5.9 ER347

● Identification Color

End Face : Blue

● Applications and Characteristics

TASETO TG347 is the welding material which has the composition of 19%Cr-9%Ni-Nb. As Nb is added, its resistibility of intergranular corrosion in polythionic acid conditions of desulfurization plant is good. Besides, it has high strength at elevated temperature. TG347 is used for welding of Type 321 and Type 347 stainless steel. TG347L whose carbon content is further decreased is also available.

● Chemical Composition of Wire (%)

	C	Si	Mn	P	S	Ni	Cr	Nb	Mo	Cu
Typical	0.030	0.46	1.75	0.010	0.008	10.05	20.33	0.52	0.11	0.13

● Mechanical Properties of All Weld Metal

	0.2% Proof Stress (MPa)	Tensile Strength (MPa)	4D Elongation (%)
Typical	491	647	40.0

● Typical Tensile Strength at High Temperature

Test Temperature (°C)	Tensile Strength (MPa)	5D Elongation (%)
550	465	23.4
650	465	21.7
750	430	18.3
850	379	13.1

● Sizes Available and Recommended Welding Currents (DCEN)

Rod Diameter (mm)	0.8	0.9	1.0	1.2	1.6	2.0	2.4	2.6	3.2	4.0	5.0
Rod Length (mm)	1000										
Welding Current (A)	50~80		50~120			100~200			150~250		220~280

*Rod Diameter 0.8, 0.9 mm : Made to order products