

TASETO Welding Materials

Stainless Steel Electrodes

For Flux Cored Arc Welding

GFW347

Applicable Specification

JIS Z 3323 TS347-FB0

AWS A5.22 E347T0-1/4

● Applications and Characteristics

TASETO GFW347 has excellent resistibility to intergranular corrosion, because of carbon stabilizing effect of Nb added in weld metal. It is used for welding of Type 347 and Type 321 stabilized stainless steel.

● Notes on Usage

* Please refer "Guideline for Welding Stainless Steel with GFW Wires".

● Chemical Composition of All Weld Metal (%)

	C	Si	Mn	P	S	Ni	Cr	Mo	Cu	Nb+Ta
Typical	0.043	0.31	1.19	0.022	0.012	9.93	19.02	0.04	0.03	0.55

● Ferrite Content of All Weld Metal

* Typical Ferrite Content: 6.3% (Schaeffler's Diagram)
7.9FN (DeLong's Diagram)
10% (Ferrite Scope)

● Mechanical Properties of All Weld Metal

	Test Temp. (°C)	0.2% Proof Stress (MPa)	Tensile Strength (MPa)	5D Elongation (%)
Typical	Room Temp.	425	611	38.0
	500	295	424	23.0
	600	278	365	19.2
	700	266	300	14.0

● Corrosion Resistance of All Weld Metal

* Typical Corrosion Resistance 0.00074 in/month(0.21 g/m²·h)
(65% Nitric Acid Test)
180° bend without any defects
(Copper Sulfate-Sulfuric Acid Test : PWHT 650°C × 2h)

● Sizes Available, Shielding Gas

Size (mm)	Shielding Gas
1.2	CO ₂ or Ar+20%CO ₂ , 20L/min
1.6	CO ₂ or Ar+20%CO ₂ , 20L/min