

# TASETO Welding Materials

Stainless Steel Electrodes

For Flux Cored Arc Welding

## GFW347L

Applicable Specification  
JIS Z 3323 TS347L-FB0  
AWS A5.22 E347T0-1/4

### ● Applications and Characteristics

TASETO GFW347L has the same uses as GFW347. As it contains less carbon than GFW347, the resistibility to intergranular corrosion is better than GFW347. GFW347L is suitable for overlay welding of Type 321 or 347 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	0.020	0.36	1.11	0.022	0.015	10.40	18.25	0.02	0.02	0.61

### ● Ferrite Content of All Weld Metal

\* Typical Ferrite Content: 5.1% (Schaeffler's Diagram)  
5.1FN (DeLong's Diagram)  
9% (Ferrite Scope)

### ● Mechanical Properties of All Weld Metal

	0.2% Proof Stress (MPa)	Tensile Strength (MPa)	5D Elongation (%)	Absorbed Energy (J at 0°C)
Typical	424	592	40.0	50

### ● Corrosion Resistance of All Weld Metal

\* Typical Corrosion Resistance 0.00074 in/month(0.21 g/m<sup>2</sup>·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 <sub>2</sub> or Ar+20%CO <sub>2</sub> , 20L/min
1.6	CO <sub>2</sub> or Ar+20%CO <sub>2</sub> , 20L/min