

SM-347



❖ Specification

AWS A5.9	ER347
JIS	Z3321 YS347
EN	ISO 14343-A G 19 9 Nb

❖ Applications

Mig Welding of 18%Cr-8%Ni-Nb(STS 347)
and 18%Cr-8%Ni-Ti(STS 321) stainless steel

❖ Characteristics on Usage

As the weld metal contains ferrite, its resistance to crack is good.
SM-347 has stabilizing element (Nb) thus providing good intergranular
corrosion resistance and better heat resistance.
Due to high creep strength at high temperature, suitable for the
welding of boiler and gas turbine.

❖ Note on Usage

Use 100% Ar or Ar + 2~5%O₂ gas.

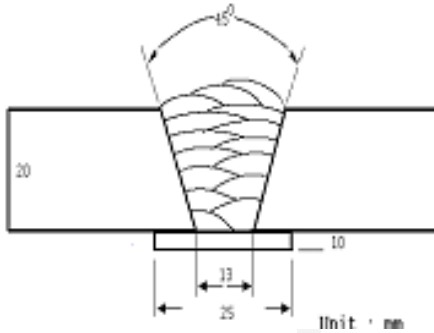
❖ Packing

Dia.(mm)	0.8	0.9	1.0	1.2	1.6
Spool (kg) *including ball pac	12.5				



Mechanical Properties & Chemical Composition of All Weld Metal

❖ Welding Conditions



[Joint Preparation & Layer Details]

- Diameter(mm)** : 1.2mm
- Shielding Gas** : Ar + 2%O₂
- Flow Rate(l /min.)** : 15~20
- Amp./ Volt.** : 230/27
- Stick-Out(mm)** : 20
- Pre-Heat(°C)** : R.T.
- Interpass Temp.(°C)** : 150 ± 15
- Polarity** : DC(+)

❖ Mechanical Properties of All weld metal(wt%)

Consumable	Tensile Test	
	TS(MPa)	EL(%)
SM-347	680	30

❖ Chemical Analysis of the wire

Consumable	C	Si	Mn	Ni	Cr	Nb
SM-347	0.06	0.43	1.56	9.6	19.5	0.7

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