

## Shield-Bright 347

FCAW wire for 18%Cr - 8%Ni – Nb stainless steel. For all-position welding. Developed to weld types 347, 304, 304L and 321 stainless. The addition of Niobium helps minimize chromium carbide precipitation while providing improved corrosion resistance.

### Specifications

|                        |                                                                                                                                                                                 |
|------------------------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| <b>Classifications</b> | SFA/AWS A5.22 : E347T1-1<br>SFA/AWS A5.22 : E347T1-4<br>JIS Z 3323 : TS347-FB1<br>KS D 3612 : YF347C<br>EN ISO 17633-A : T 19 9 Nb P C1 2<br>EN ISO 17633-A : T 19 9 Nb P M21 2 |
| <b>Approvals</b>       | DNV-GL : VL 347 (C1)<br>NAKS/HAKC : 1.2mm                                                                                                                                       |

Approvals are based on factory location. Please contact ESAB for more information.

|                        |                        |
|------------------------|------------------------|
| <b>Welding Current</b> | DC+                    |
| <b>Alloy Type</b>      | C Cr Ni                |
| <b>Shielding Gas</b>   | M21, C1 (EN ISO 14175) |

### Typical Tensile Properties

| Condition               | Yield Strength | Tensile Strength | Elongation |
|-------------------------|----------------|------------------|------------|
| <b>C1 Shielding Gas</b> |                |                  |            |
| As Welded               | 430 MPa        | 620 MPa          | 45 %       |

### Typical Charpy V-Notch Properties

| Condition               | Testing Temperature | Impact Value |
|-------------------------|---------------------|--------------|
| <b>C1 Shielding Gas</b> |                     |              |
| As Welded               | -196 °C             | 29 J         |
| As Welded               | -29 °C              | 55 J         |

### Typical Weld Metal Analysis %

| C                       | Mn   | Si   | S    | P    | Ni   | Cr   | Cu   |
|-------------------------|------|------|------|------|------|------|------|
| <b>C1 Shielding Gas</b> |      |      |      |      |      |      |      |
| 0.04                    | 1.10 | 0.80 | 0.01 | 0.02 | 9.95 | 19.0 | 0.15 |

### Deposition Data

| Diameter | Current   | Voltage | Wire Feed Speed | Deposition Rate |
|----------|-----------|---------|-----------------|-----------------|
| 1.2 mm   | 130-220 A | 24-29 V | 5.8-14.4 m/min  | 1.9-4.6 kg/h    |