

# Supercore™ 347

## TOP FEATURES

- High deposition flat / horizontal wire
- Improved bead appearance
- Used to weld titanium and niobium stabilized 18/8 stainless steel types 321 and 347

## TYPICAL APPLICATIONS

- General fabrication
- Pharmaceutical Equipment
- Chemical Processing

## CLASSIFICATION

AWS A5.22	E347T0-1/4
EN ISO 17633-A	T19 9 Nb R C/M 3
EN ISO 17633-B	TS347-F C1/M21 0

## CURRENT TYPE

DC+

## WELDING POSITIONS

Flat/Horizontal

## SHIELDING GASES (ACC. EN ISO 14175)

M21	Mixed gas Ar+ 15-25% CO <sub>2</sub>
Flow rate	15-25 l/min

## CHEMICAL COMPOSITION (WEIGHT %), WELD METAL

	C	Mn	Si	S	P	Cr	Ni	Mo	Nb	Cu	FN
Min.		0.5				18.0	9.0		8xC		4
Max.	0.08	2.0	1.0	0.025	0.030	21.0	11.0	0.3	1.0	0.3	12
Typical	0.03	1.2	0.4	0.01	0.02	19	10.5	0.1	0.5	0.1	8

## MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

As welded	Min.	Typical
Tensile strength (MPa)	550	600
0.2% Proof strength (MPa)	350	435
Elongation (%) 4d	30	47
5d	25	42
Reduction of area (%)		50
Impact ISO-V (J) +20°C		90

## PACKAGING AND AVAILABLE SIZES

Wire diameter (mm)	Packaging	Weight (kg)	Item number
1.2	SPOOL (S300)	15.0	SC347-12

## TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application.

Safety Data Sheets (SDS) are available here:



Subject to Change – The information is accurate to the best of our knowledge at the time of printing. Please refer to [www.lincolnelectric.eu](http://www.lincolnelectric.eu) for any updated information.