

Shield-Bright 347

AWS A5.22 E347T1-1(4) / JIS Z3323 TS347-FB1

Flux
CORED
WIRES

Description and Application

- Shield-Bright 347 was developed for the welding of stainless steel types 321 and 347. As with all 347 weld metals, for service at temperatures greater than 1000 °F (550 °C) it can be used in circumstances of lower stress and not under creep conditions. Shield-Bright 347 can also be used for the welding of types 302, 304 and sometimes 304L stainless steels. Shield-Bright 347 was developed for welding in all positions and performs particularly well in the vertical position with excellent slag removal.

Shielding Gas : 100%CO₂ or 75%Ar/25%CO₂

Typical Mechanical Properties of All Weld Metal

Shielding gas	Yield Point N/mm ² {kgf/mm ² }	Tensile Strength N/mm ² {kgf/mm ² }	Elongation (%)
100%CO ₂	433 {44}	622 {63}	47
75%Ar/25%CO ₂	520 {53}	650 {66}	35

Typical Undiluted Weld Metal Analysis %

Shielding gas	C	Mn	Si	P	S	Cr	Ni	Mo	Ferrite No.
100%CO ₂	0.045	1.10	0.80	0.027	0.010	18.7	10.0	0.40	3-8
75%Ar/25%CO ₂	0.030	1.20	0.90	0.020	0.007	19.5	10.0	0.45	3-8