

Shield-Bright 347H

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

Description and Application

- Shield-Bright 347H was developed for the welding of stainless steel types 321 and 347 where a minimum of 0.04% carbon is required. 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 advisedly under creep conditions. Shield-Bright 347H can also be used for the welding of types 302 and 304 stainless steels. Shield-Bright 347H was developed for welding in all positions and performs particularly well in the vertical position with excellent slag removal.

Flux
CORED
WIRES

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	450 {46}	650 {66}	40
75%Ar/25%CO ₂	520 {53}	650 {66}	35

Typical Undiluted Weld Metal Analysis %

Shielding gas	C	Mn	Si	P	S	Cr	Ni	Nb	Ferrite No.
100%CO ₂	0.060	1.00	0.50	0.020	0.010	18.5	9.8	0.55	3-8
75%Ar/25%CO ₂	0.060	1.10	0.85	0.020	0.010	19.5	9.7	0.60	3-8