

# ESSEN<sup>®</sup> FC 347

Flux cored wire for welding of 18% Cr, 8% Ni with stabilizing element Nb. Deposited structure is austenite and contains small amount of ferrite. The stabilizing element reduces the possibility of precipitation of intracrystalline chromium carbide, thereby improving the resistance to intergranular corrosion.

<b>GRADE</b>	AWS A5.22 E347 T1-1
<b>PROPERTIES</b>	<ul style="list-style-type: none"> <li>• All position wire with exhibiting excellent smooth beads.</li> <li>• Provides excellent arc stability, low spatter and high deposition.</li> <li>• Self-peeling slag and easy post weld finishing.</li> <li>• Widely used in food machinery fabrication, medical equipment, pressure vessels, petrochemicals etc, such as welding of 07Cr19Ni11Ti (SUS 321), 07Cr18Ni11Nb (SUS 347).</li> </ul>

### TYPICAL ANALYSIS OF ALL-WELD METAL %

C	Si	Mn	P	Cr	Ni	Mo	Nb+Ti
0.02	0.45	1.45	0.015	18.00-21.00	9.00-11.00	0.5	0.48

### TYPICAL ANALYSIS OF ALL-WELD METAL %

Tensile Strength Mpa	Yield Strength Mpa	Elongation %	Impact test J 0°C
590	---	40	55-58

### WELDING PARAMETERS

Polarity	Shielding Gas	Amps A	Voltage V
DC+	75%Ar/ CO <sub>2</sub> 25% 100%Co <sub>2</sub>	150-240	24-32

### PACKING

Wire Dia in MM.	Packing per spool
1.20	12.5 Kgs



**ESSEN**

**WELDING ALLOYS PVT. LTD.**

(Formerly known as Asugar Engineers Pvt. Ltd.)

An ISO 9001-2015 Certified Company

'Sai maa', At Kawadi Post: Kadam Wak Wasti via Loni Kalbhor,  
Post P.B. No.1, Tal.: Haveli, Dis.: Pune 412201, INDIA

Tel.: +91 90280 81493

Email: [adityagujar@essenwelding.com](mailto:adityagujar@essenwelding.com)/[info@essenwelding.com](mailto:info@essenwelding.com)

Website: [www.essenwelding.com](http://www.essenwelding.com)