

# Stainless Steel Gas Shielded type FCW

## KF347

AWS A5.22 E347T1-1

### Product Features:

- KF347 is similar to KF308 but niobium stabilized.
- Smooth arc, low spatter loss and easy slag removal.
- Deep penetration and easy to obtain the flat equal weld leg.
- The content of niobium helps minimize carbide precipitation and obtain more resistance to inter-granular corrosion.

### Applications:

- Suitable for welding of stainless steel such as SUS 301, 302, 304, 303L, 304, 321, 347, 347H.

Typical chemical composition of all-weld metal (wt%)

C	Si	Mn	Cr	Ni	Nb	Mo	S	P
0.05	0.6	1.5	19.5	10	0.6	0.05	0.011	0.017

Typical mechanical properties of all weld metal

Yield Strength N/mm <sup>2</sup>	Tensile Strength N/mm <sup>2</sup>	Elongation %
490	620	38

Size (mm) & recommended welding parameters

Diameter		1.2mm	1.6mm
Polarity		DC+	DC+
Ampere (A)	Flat position	160~250	220~300
	Vertical up position	90~130	----
Voltage	Flat position	22~32	24~30
	Vertical up position	20~24	----
Shielding Gas		CO <sub>2</sub>	CO <sub>2</sub>

### Note:

- Use general CO<sub>2</sub> welding machine with proper feed roller pressure.

**ecoweld**<sup>®</sup>

CMI

50 Toegye-ro 18-gil, Jung-gu  
Seoul, South Korea  
www.ecoweldkorea.com