

## MIG/MAG Cored Wires Stainless and Heat resistant steels

FLUXINOX 347-PF is an alloyed rutile flux cored wire with a fast-freezing slag for the welding of stabilized corrosion resistant Cr Ni-steel. The weld metal is suitable for operating temperatures up to 400°C, non-scaling up to approximately 800°C. FLUXINOX 347-PF exhibits outstanding, easy slag removal from fillet welds, even in acute angles. Welds produced are flat and smooth without undercut and due to only slight discolouration of the welds, pickling costs can be minimised. Owing to the fast-freezing slag, FLUXINOX 347 PF is used for welding in the horizontal (PD), overhead (PE) and vertical-up (PF) positions.

Classification	
EN ISO	17633-A: T 19 9 Nb P C 1
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EN ISO	17633-B: TS347L-FB1
EN ISO	A5.22: E347T1-1
AWS	A5.22: E347T1-4

### Chemical analysis (Typical values in %)

C	Mn	Si	Cr	Ni	Nb	Ferrite
≤ 0.04	1.5	0.9	20	10	0.4	5-10

### All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation A5 (%)	Impact Energy ISO - V (J)	
				20 °C	-196 °C
As Welded	≥ 350	≥ 550	≥ 30	≥ 47	≥ 32

Gas test: 82% Ar+18% CO2

### Shielding Gas - EN ISO 14175 : C1, M21

### Materials

1.4541 (X6CrNiTi18-10); 1.4301 (X4CrNi18-10); 1.4550 (X6CrNiNb18-10);

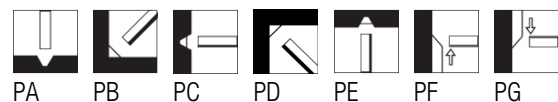
AISI 347 - 321

### Storage

Keep dry and avoid condensation

### Current condition and welding position

DC+



### Packaging data

Packaging Type	BS300
Diam(mm) / weight(kg)	15
1,2	●
1.0	●