



ENAR WELD BRAZE PVT. LTD

A-112, DDA INDUSTRIAL SHEDS,
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KISWEL K-347T

Classifications:

EN ISO 17633-A: 2008: T 19 9 Nb P C 1
EN ISO 17633-B: 2008: TS316L-FB0
AWS A5.22-07: E347T1-1

KS D 3612: YF-347C
JIS Z 3323: TS347-FC1

Typical Chemistry Composition of Weld Deposit:

Shielding Gas	C	Si	Mn	Cr	Ni	Nb
CO ₂	<0.08	<1.00	0.50 – 2.50	18.00 – 20.00	9.00 – 11.00	<1.00

Description:

- K-347T is formulated for MAG welding of 19%Cr-9%Ni-Nb stainless steels. (AISI 347, 321, ASTM A296; A157 Gr. C9; A320 Gr. B8C or D)
- Wire is a titania type of flux cored wire for all-position welding and it has low spatter generation, easy slag removal and good weld soundness.
- Nb component improves the resistance to intergranular corrosion of the weld metal.
- The weld metal contains optimum ferrite contents in their austenitic structures, Therefore their weldability is excellent with lower crack susceptibility.

Typical Mechanical Properties:

Yield Strength
(Mpa)
min. 350

Tensile Strength
(Mpa)
Min. 520

Elongation
(%)
min. 30