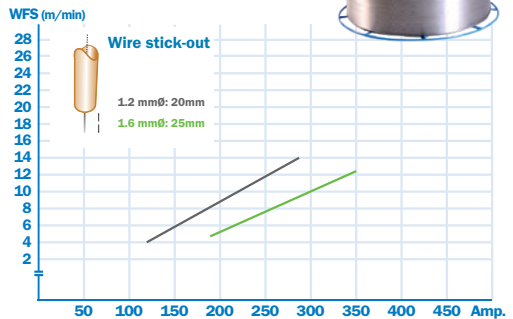
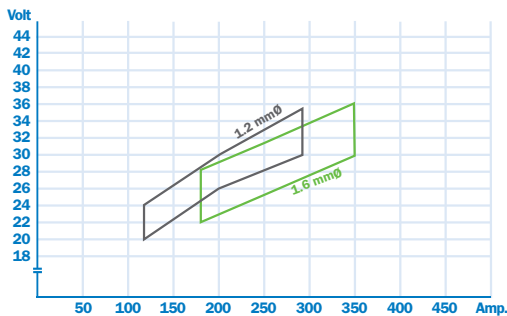


Description and Application

DW-347LH is an all positional flux cored wire for welding titanium or niobium stabilized stainless steel such as 18%Cr-8%Ni-Ti or 18%Cr-8%Ni-Nb stainless steels. Due to the high niobium content in the weld metal, it is possible to prevent Cr-carbide precipitation which leads to intergranular corrosion.



Recommended Parameter Range, for flat position*



Typical Chemical Analysis (wt. %)*

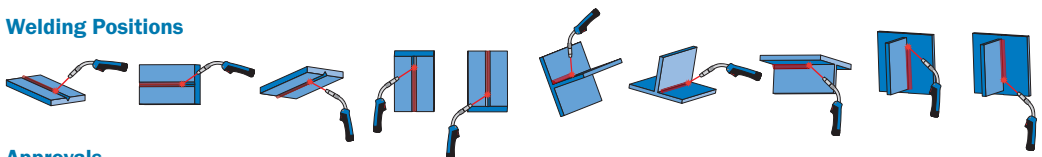
C	Si	Mn	P	S	Ni	Cr	Mo	N	Nb	FS	FN	FNW
0.03	0.60	1.30	0.018	0.004	10.4	18.7	-	-	0.6	6.7	7.3	6.3

Typical Mechanical Properties*

	R _e (MPa)	R _m (MPa)	A ₅ (%)	CV(J)+20°C	CV(J)0°C
Guaranty	440	617	37	90	84
	min.350	min.550	min.30		

* The above values and parameters are for all weld metal produced using Ar+CO₂ shielding gas

Welding Positions



Approvals

LR	DNV GL	BV	ABS	R.M.R.S	Others
-	-	-	-	-	TÜV, CE