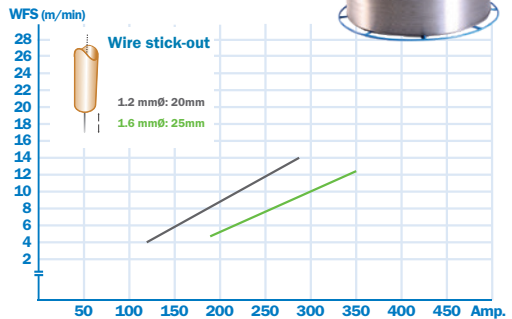
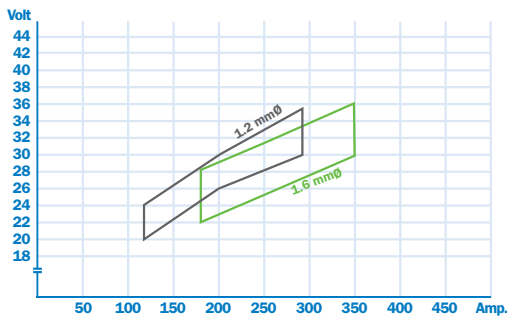


Description and Application

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. %)*

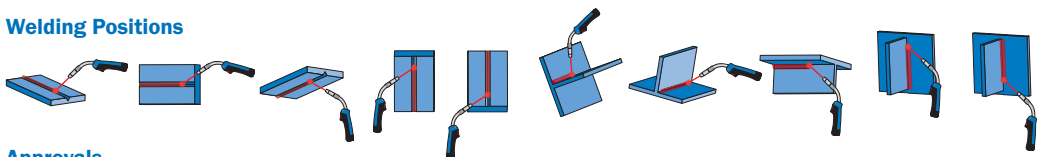
| C | Si | Mn | P | S | Ni | Cr | Mo | N | Nb | FS | FN | FNW |
|------|------|------|-------|-------|------|------|----|---|-----|-----|-----|-----|
| 0.03 | 0.60 | 1.30 | 0.018 | 0.004 | 10.4 | 18.7 | - | - | 0.6 | 6.7 | 7.3 | 6.3 |

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 | BV | ABS | R.M.R.S | Others |
|----|-----|----|-----|---------|---------|
| - | - | - | - | - | TÜV, CE |