

# GMAW Solid Wire for Stainless Steel

## KMS-347H

### Classification

AWS A5.9/A5.9M ER347

JIS Z3321 YS347

EN 14343-A G 19 9 Nb

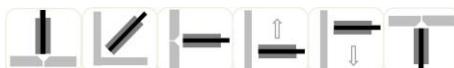
YB T5092 -

Shielding Gas: Ar+1~2%O<sub>2</sub>(CO<sub>2</sub>)

### Applications and Features

- ( 1 ) Weld metal is austenitic structure with 19%Cr-9%Ni-Nb.
- ( 2 ) The addition of niobium reduces intergranular corrosion in severe operating conditions.
- ( 3 ) The high carbon deposit provides creep strength and a high tensile strength at elevated temperatures
- ( 4 ) Ideal for welding AISI 308H, 321 and 347 stainless steel plates.

### Welding Position



### Welding Instruction

- ( 1 ) Use Ar+1~2%O<sub>2</sub> for spray transfer and Ar+1~2%CO<sub>2</sub> for short-circuit transfer.
- ( 2 ) For other instructions, please refer to Appendix B and F.

### Typical Chemical Composition of Weld Metal (wt%)

C	Si	Mn	P	S	Cr	Ni	Nb
0.06	0.41	1.63	0.012	0.010	20.12	9.87	0.68

### Typical Mechanical Properties of Weld Metal

Tensile Strength N/mm <sup>2</sup>	Yield Strength N/mm <sup>2</sup>	Elongation %		
			610	450

### Size and Suggested Operating Range (DC+)

Diameter (mm)	0.8	0.9	1.0	1.2	1.4	1.6
Ar+1~2%CO <sub>2</sub>	Current (A)	40~120	60~140	80~160	100~210	-
	Voltage (V)	15~20	15~21	16~22	17~22	-
Ar+1~2%O <sub>2</sub>	Current (A)	160~210	170~260	180~280	200~300	210~320
	Voltage (V)	24~28	24~30	24~30	24~30	24~32