SelectAlloy 347T0-3

Description:

SelectAlloy 347T0-3 is a self-shielded, flux cored, stainless steel electrode designed to weld in the flat and horizontal positions. It has a nominal weld metal composition of 20% chromium, 10% nickel and 0.7% columbium The columbium forms a stable carbide. This reduces chromium carbide precipitation and makes the weld metal more resistant to intergranular corrosion. **SelectAlloy 347T0-3** is designed to be used without a shielding gas. It should not be run under a shielding gas.

Classification:

- E347T0-3 per AWS A5.22

Characteristics:

SelectAlloy 347T0-3 produces a flat, well washed bead. The arc transfer is globular, with low spatter. Penetration is lower than with gas shielded wires, making it ideal for surfacing or welding over gaps.

Applications:

SelectAlloy 347T0-3 is used to weld types 321, 347 and 348 stainless steel. It may also be used for the cladding of carbon steels.

Typical Deposit Composition (CO_2):

Shielding Gas	C	Cr	Ni	Cb	Mn	Si	N
100 CO_2	0.05	20.00	10.00	0.70	1.10	0.70	0.10

Ferrite Number (WRC, 1992) - 5

* The nitrogen levels in self-shielded stainless steel deposits can vary widely depending on the welding parameters used. Since nitrogen has a strong effect on the ferrite level (increasing nitrogen lowers the ferrite number) careful control of parameters is necessary to maintain consistent ferrite levels.

Typical Welding Parameters (DCEP):

Diameter	WFS (ipm)	Amperage	Voltage	ESO (in.)
.045"	180	100	24-26	5/8"- ¾"
	240	125	24-27	5/8"- ¾"
	300	145	25-28	5/8"- ¾"
	400	170	27-30	5/8"- ¾"
	500	190	29-31	5/8"- ¾"
1/16"	150	125	27-30	¾"-1"
	200	155	29-32	¾"-1"
	250	190	28-31	¾"-1"
	300	215	30-33	¾"-1"
	350	240	31-33	¾"-1"
3/32"	135	250	25-27	1¼"-1½"
	180	300	27-29	1¼"-1½"
	225	350	28-30	1¼"-1½"
	300	400	29-31	1¼"-1½"
	340	450	29-31	1¼"-1½"

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