**ULTRA SS347LT1-1  
FLUX CORED WIRE**

**AWS A/SFA 5.22  
SS347LT1-1**

## CLASSIFICATION:

* EN ISO 17633-A
* T 19 9 Nb L R C/M 1
* TS347LT1-1
* AWS A/SFA 5.22
* SS347LT1-1



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| --- | --- |
|  |  |
| * All position capability | Petrochemical industry |
| * Excellent resistance to intergranular corrosion | * High temperature piping |
| * Stabilized with Niobium for superior weld metal performance | * Welding of AISI 321/347 stainless steel |
| * Smooth arc characteristics and easy slag removal | * Pressure vessels |
| * Low spatter and high deposition rate | * Power generation components |
| * Suitable for single and multi-pass welding | * Heat exchangers and boilers |



|  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- |
| C – 0.04 | Mn – 1.7 | Si – 0.5 | Cr – 19.5 | Ni – 10.5 | Nb – 0.6 |

## 

|  |  |  |  |  |
| --- | --- | --- | --- | --- |
| Condition | UTS, MPa | YS at 0.2% offset, MPa | EL% | CVN Impact, J at -20°C |
| As Welded | 570 | 410 | 28 | 50 |

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|  |  |
| --- | --- |
| Ø x L mm | Amperage, A |
| 1.2 | 130–280 |
| 1.6 | 200–360 |



Available in Vacuum Pack of 15 kg wire layer wounded on Plastic Spool.

