

# 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

## TYPICAL APPLICATIONS:

- Petrochemical industry
- High temperature piping
- Welding of AISI 321/347 stainless steel
- Pressure vessels
- Power generation components
- Heat exchangers and boilers

## KEY FEATURES:

- All position capability
- Excellent resistance to intergranular corrosion
- Stabilized with Niobium for superior weld metal performance
- Smooth arc characteristics and easy slag removal
- Low spatter and high deposition rate
- Suitable for single and multi-pass welding

## TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL WT (%):

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

## MECHANICAL PROPERTIES OF ALL WELD METAL:

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

## PARAMETERS & PACKING DATA:

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

## DCEP(Electrode Positive)

Use 1-2 volts lower when using mix shielding gas

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



## DCEP

Electrode Positive

All positions except vertical down



Use 1-2 volts lower when using  
mix shielding gas