



Supplier of Welding Alloys

Stainless Steel Flux Cored Wire

Oxford Alloy® 347T-1

SPECIFICATIONS

AWS 5.22
ASME SFA 5.22

CLASSIFICATIONS

AWS E347T1-1/T1-4
UNS W34731

DESCRIPTION / APPLICATION

Oxford Alloy E347T1-1/T1-4 was developed to weld types 347, 304, 304L and 321 stainless, where service temperatures are below 600°F (316°C). The addition of columbium helps minimize chromium carbide precipitation while providing improved corrosion resistance. Oxford Alloy E347T1-1/T1-4 was developed for out-of-position welding. This flux cored wire will deposit out-of-position welds at substantially higher welding currents than other stainless steel flux cored wires, resulting in a higher deposition rate. The slag is self-peeling and minimizes cleanup. Oxford Alloy E347T1-1/T1-4 was formulated for use with 75% Argon/25% CO² shielding gas; however, straight CO² may also be used. The 75/25 mixture will produce a smooth arc with virtually no spatter and slightly higher yield and tensile strengths than CO². The mechanical properties and deposit analysis will meet AWS 5.22 specifications with either gas.

AWS Chemical Composition						
C	Mn	Si	Cr	Ni	Cb+Ta	Mo
0.08 max	0.5-2.5	1.0 max	18.0-21.0	9.0-11.0	8 x C min/1.0 max	0.5 max
P	S	Cu				
0.04 max	0.03 max	0.5 max				

TYPICAL MECHANICAL PROPERTIES

Tensile strength: 94,250 psi 650 MPa

Yield strength: 69,600 psi 480 MPa

Elongation: 34%

Please contact our sales department for more information at 800-562-3355 or 225-273-4800.

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