

FLUX CORED

Oxford Alloy® 347T1-1/4

AWS E347T1-1/T1-4 • Stainless Steel

Key Features

- ❖ Designed for all-position welding
- ❖ Provides superior weld performance and enhanced operator appeal.
- ❖ Hermetically sealed packaging to ensure freshness.

Conformances

AWS/ASME SFA 5.22
E347T1-1/T1-4
UNS W34731



| Chemical Composition - As required per AWS 5.22 | | | | | | |
|---|----------|----------|-----------|----------|---------------------|----------|
| C | Mn | Si | Cr | Ni | Nb+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 | 0.75 max |
| P | S | Cu | | | | |
| 0.04 max | 0.03 max | 0.75 max | | | | |

| Mechanical Properties - As required by AWS 5.22 | | | | |
|---|-------------------------------|-----------------------------|-----------------|---|
| | Tensile Strength MPa (ksi) | Yield Strength MPa (ksi) | Elongation % | Charpy V-Notch J (ft-lbf) @ 20 °C (68 °F) |
| AWS Requirements | 520 (75) min | Not Specified | 30 min | Not Specified |
| Typical Results - As welded | 650 (94) | 480 (70) | 34 | 61 (45) |

Recommended Shielding Gas

100% CO₂
75% Argon / 25% CO₂

| Diameter | Typical Welding Parameters | | | | | | | |
|--------------------------|----------------------------|------|------|------|---------------|------|------|-------|
| | .045 (1.14mm) | | | | 1/16" (1.6mm) | | | |
| Amperage | 130 | 165 | 190 | 220 | 170 | 210 | 250 | 300 |
| Voltage | 25 | 26 | 28 | 30 | 25 | 27 | 28 | 29 |
| Wire Feed speed (in/min) | 227 | 341 | 445 | 567 | 154 | 193 | 243 | 321 |
| Deposition rate (lbs/hr) | 4.25 | 6.14 | 8.08 | | 5.34 | 6.89 | 8.57 | 11.43 |
| % Efficiency | 84.0 | 83.0 | 84.0 | 84.0 | 83.0 | 82.5 | 83.0 | 83.0 |

The ESO (Electrical Stick Out) is 1/2" - 1". DCEP (electrode positive) is specified. When using 75% Argon / 25% CO₂ mixture, decrease voltage by as much as 2 volts.

| Diameters & Packaging | | | | | |
|-----------------------|----------------------|--------------------|----------------------------|----------------------|--------------------|
| Oxford Alloys USA | | | Oxford Alloys Asia Pacific | | |
| Diameter (in) | Spool Dimension (in) | Spool Weight (lbs) | Diameter (mm) | Spool Dimension (mm) | Spool Weight (kgs) |
| .045 | 12 | 33 lb spool | 1.2 | 300 | 15 kg spool |
| 1/16 | 12 | 33 lb spool | 1.6 | 300 | 15 kg spool |

Actual test results may vary. Refer test result disclaimer on page 160.