

DESCRIPTION

Executive 347 wire is designed to provide clean and consistent welds with excellent feedability and minimal clean-up. By maintaining tight control from the country of melt to the design of the spool Executive wire provides welders with the highest quality stainless bare wire.

Executive 347 contains the addition of niobium thereby reducing the possibility of intergranular carbide precipitation and thus susceptibility to intergranular corrosion.

Executive 347 has an austenite structure with 20% Cr- 10% Ni-Nb gives better intergranular corrosion resistance and strength.

APPLICATIONS & FEATURES

Executive 347 is used for welding chromium-nickel stainless steel base metals of similar composition stabilized with either Niobium, Titanium, or tantalum; the addition of which stabilizes carbon providing greater strength at elevated temperatures.

Executive 347 has a ferrite level of 4-10 as per WRC-92.

TYPICAL WIRE CHEMISTRY & MECHANICAL PROPERTIES

C	Cr	Ni	Mo	Mn	Si	P	S	Cu	N	Nb
0.052	19.04	9.07	0.07	1.53	0.41	0.022	0.001	0.10	0.049	0.70
Tensile Strength:		89,900 PSI min		Yield Strength:		65,300 PSI min		Elongation:		41%

TYPICAL WELDING PARAMETERS

Process	Diameter	Voltage	Amperage	Gas Flow	Shielding Gas / Flux	
GMAW - Short	.035"	21-22	160-200	30 to 50 CFH	90% He/7.5% Ar/2.5% CO ₂ or 1%-5% O ₂ /Balance Ar	
	.045"	22-23	180-210			
	.062"	23-24	200-220			
	- Spray	.035"	23-25			190-260
		.045"	25-28			250-330
		.062"	28-31			310-350
GTAW	.062" - .125"	Direct Current; Electrode -		30 to 40 CFH	100% Ar	
SAW	.093"	29-32	300-350		Record IND 24 or Record IN	
	.125"	29-32	400-550			

STANDARD PACKAGING

GMAW (MIG)	33-lb wire baskets	1,980-lb pallet
	11-lb plastic spools	11-lb box
	2-lb plastic spools	8-lb box
GTAW (TIG)	10-lb plastic tube	40-lb box
SAW	60-lb wire coil	1,200-lb pallet

CLASSIFICATION

AWS/SFA 5.9, Class **ER347**

Certified by the Canadian Welding Bureau (CWB) to AWS A5.9.

