



347LT1-1 Flux Cored Wire

U.S. ALLOY CO.
dba Washington Alloy
7010-G Reames Rd.
Charlotte, NC 28216
www.weldingwire.com

Quality Management System
in accordance with
ISO 9001
Cert # 05-R0925



ALLOY DESCRIPTION AND APPLICATION;

E347T1-1 is a flux-cored wire for single or multi-pass welds on AISI types 304, 304L, 321 and 347 stainless steels. E347T1-1 is noted for its low spatter generation, excellent bead shape and appearance and ease of slag removal. It has very good deposit efficiency when used for flat and fillet welds of medium and heavy thickness plates. It has been designed to be used with 100% CO2 shield gas. The columbium content of E347T1-1 provides weld deposits with improved resistance to chromium carbide precipitation and improved corrosion resistance as well as improved strength at higher temperatures. E347T1-1 is used extensively in the fabrication of AISI types 321 and 347 stainless steel structures, pressure vessels, tanks in dairy, pulp and paper, textile dyeing, refinery and chemical equipment. The extra low carbon content reduces carbide precipitation. E347T1-1 can be used to weld stainless steels of similar compositions when welds are required to meet higher corrosion resistance and higher creep strength requirements along with intergranular corrosion resistance requirements

TYPICAL WELDING PROCEDURES; DCEP

Wire Diameter	Wire Speed (ipm)	Amps	Volts	Electrical Stickout	CO ₂ (cfh)
0.045"	215-550	140-380	23-35	1/2-1"	35-50
1/16"	125-615	150-410	24-36	5/8-1.25 "	35-50

Procedures may vary with change in position, base metals, filler metals, equipment and other changes.

CHEMISTRY (%) for Undiluted WELD METAL & PROPERTIES

	AWS Requirements)	Typical		(AWS Requirements)	Typical
Carbon	0.08	0.04	Molybdenum	0.75	0.59
Manganese	0.5-2.5	1.07	Phosphorus	0.04	0.014
Silicon	1.00	0.71	Sulfur	0.03	0.016
Chromium	18.0-21.0	19.65	Nickel	9.0-11.0	10.13
		Niobium (Nb) or Cb + Ta		8XC min. -1.0 max.	0.54
		AWS Requirements		As Welded	
Tensile Strength (psi)		75,000 min.		96,600	
Yield Strength (psi)		N/A		63,750	
Elongation		30% min.		33%	

Iron balance and all single values are maximum percentages unless noted

AVAILABLE SIZES: TSF 347LT

Other sizes available – please inquire

SPECIFICATIONS; ANSI/AWS A5.22 E347LT0-1/-4 or E347LT1-1/-4
ASME SFA 5.22 E347LT0-1/-4 or E347LT1-1/-4
ASME F-6 , A-8

T0 = flat and horizontal; T1 = all position; -1 is for 100% CO2; -4 = 75-80 Ar /CO2

EAST COAST	GULF COAST	WEST COAST
7010-G Reames Rd	4755 Alpine Drive #100A	8535 Utica Ave
Charlotte, NC 28216	Stafford, TX 77477	Rancho Cucamonga, CA 91730
Tel (888) 522-8296	Tel (877) 711-9274	Tel (800)830-9033
Fax (704)598-6673	Fax (281)313-6332	Fax (909)291-4586



Warehouse Distribution Center – Portland, Oregon

Head Office – Puyallup,

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