**DESCRIPTION:**
SFC-347L is a rutile flux cored tubular wire for all-positional welding using pure CO2 shielding gas. It performs with smooth arc transfer, self-releasing slag, low spatter level, fine ripple etc. It provides good corrosion resistance in service temperature up to 760°C.

**APPLICATIONS:**
Designed for welding stabilized stainless steels such as type 347 and 321, resistance overlay, joining of common austenitic stainless steel types 301, 302, 304, 304L and CF-8.

**NOTE ON USAGE:**
1. Use DC (+) polarity.
2. Maintain a higher welding speed in order to get enough penetration in the down hand welding position.

**WELDING POSITION:**

![Welding Positions]

**TYPICAL CHEMICAL COMPOSITION OF WELD METAL (wt%):** *(Shielding Gas: 100% CO2)*

Weld Metal Analysis:
- Carbon (C) 0.031
- Manganese (Mn) 0.93
- Silicon (Si) 0.54
- Phosphorus (P) 0.019
- Sulphur (S) 0.014
- Nickel (Ni) 10.28
- Chromium (Cr) 19.28
- Niobium (Nb) 0.48

**TYPICAL MECHANICAL PROPERTIES OF WELD METAL:** *(Shielding Gas: 100% CO2)*

- TS N/mm² 572
- EL% 41

**TYPICAL IMPACT VALUES:**
- IV 0°C J 48

**APPROVALS:**
ABS

**SUGGESTED WELDING PARAMETERS (DC <->)**

<table>
<thead>
<tr>
<th>Parameters</th>
<th>Diameter (mm)</th>
<th>1.2mm</th>
<th>1.6mm</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td></td>
<td>F, HF</td>
<td>V-UP, OH</td>
</tr>
<tr>
<td>Welding Position</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Voltage (Volt)</td>
<td></td>
<td>23 ~ 33</td>
<td>25 ~ 30</td>
</tr>
<tr>
<td>Current (Amp)</td>
<td></td>
<td>130 ~ 220</td>
<td>120 ~ 200</td>
</tr>
</tbody>
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