

MIDALLOY MASTERCOR™ E347T1-1,4 A/P DATA SHEET

CLASSIFICATION

- AWS 5.22 Class E347T1-1,4 / ASME SFA 5.22 Class E347T1-1,4. This product can be run with 100% CO2 shielding gas or 75% Argon 25% CO2 mixed gas. Reference UNS W34731

DESCRIPTION

- Midalloy Mastercor™ E347T1-1,4 AP is an all position flux-cored wire used to weld 347 and 321 stainless. Mastercor E347T1-1,4 AP has excellent slag removal and runs with a spatter free globular transfer. The weld deposit has 5-15 % ferrite. Niobium is used as the stabilized element for this austenitic stainless steel flux cored wire.

APPLICATIONS

- Typical applications include welding, repairing and overlaying of stabilized grades of stainless steel like type 347 and type 321.
- ER347 is used in the refinery industry to combat high temperature erosion corrosion and fatigue.
- Other welding applications include valves, valve seating surfaces , gears, propeller shafts, and impellers.
- Normally ER347 is normally used to weld AISI 321 since titanium will not transfer across the arc.

TYPICAL CHEMISTRY

C	Mn	Si	Cr	Ni	Mo	Cu	Nb(Cb)*	S	P	
0.06	1.84	.63	20.2	10.35	0.2	0.3	0.68	.015	.015	

* Cb is 8 times the carbon content to a maximum of 1.0%

FERRITE CONTENT 5 to 15 WRC 1992

TYPICAL MECHANICAL PROPERTIES*

TENSILE STRENGTH	88,000 PSI
YIELD STRENGTH	55,000 PSI
ELONGATION IN 2"	40%

Toughness 35 FT-LB @ 32°F

WELDING PARAMETERS (WITH CO2 SHIELDING GAS)

DIAMETER	VOLTAGE	AMPERAGE(WIRE FEED SPEED ipm)	
		FLAT	VERTICAL & OVERHEAD
.045"	24-28	130-200(250 to 425)	120-160(225 to 300)
1/16"	25-30	180-250(150 to 250)	180-220(150 to 200)

NOTE: IF USING MIXED GAS, VOLTAGE CAN BE INCREASED BY 2 VOLTS.

STANDARD PACKAGING

- .045" 33 lb. SPOOL
- 1/16" 33 lb. SPOOL

The contents of this publication are presented for informational purposes only, and while every effort has been made to ensure their accuracy, they are not to be construed as warranties or guarantees, express or implied, regarding the products or services described herein or their use or applicability. We reserve the right to modify or improve the designs or specifications of such products at any time without notice.

Office and Corporate Warehouse
 630 Axminister Dr.
 Fenton, MO 63026 • 636-349-6000 • 800-776-3300
 Fax 636-349-2240

