

# Stainless Steel Flux Cored Wire

## GMX347

AWS A5.22 E347T1-1/4  
A5.22M E347T1-1/4  
JIS Z 3323 TS347-FB1  
ISO 17633-A-T 19 9 Nb P C1 1, M21 1

### Product Features:

- GMX347 is similar to GMX308 but niobium stabilized.
- Smooth arc, low spatter loss and easy slag removal.
- Deep penetration and easy to obtain the flat equal weld leg.
- The content of niobium helps minimize carbide precipitation and obtain more resistance to inter-granular corrosion.

### Applications:

- Suitable for welding of stainless steel such as SUS 301, 302, 304, 303L, 304, 321, 347, 347H.

Typical chemical composition of all-weld metal (wt%)

C	Si	Mn	Ni	Cr	Nb	Mo	Fe
0.05	0.60	1.5	10	19.5	0.60	0.05	Bal.

Typical mechanical properties of all weld metal

Yield Strength N/mm <sup>2</sup>	Tensile Strength N/mm <sup>2</sup>	Elongation %
512	654	35

Size (mm) & recommended welding parameters

Diameter		1.2mm	1.6mm
Polarity		DC+	DC+
Ampere (A)	Flat position	160~250	220~300
	Vertical up position	90~130	----
Shielding Gas		CO <sub>2</sub> /80%Ar+20%CO <sub>2</sub>	CO <sub>2</sub> /80%Ar+20%CO <sub>2</sub>

### Note:

Goodweld Corporation  
No.99, Huangong Rd. Yongkang Tainan, Taiwan  
Phone: 886-6-2331003 Fax: 886-6-2333213  
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