

KOBELCO FCW Data Sheet 15

DW-347

**Classification : AWS A5.22 E347T0-1
AWS A5.22 E347T0-4**

**All-Weld-Metal (100% CO₂)
15-I. Chemical Composition**

Unit : wt%

	C	Mn	Si	P	S	Ni	Cr	Cb	N
DW-347	0.05	1.64	0.39	0.021	0.010	9.68	19.16	0.63	0.012
E347TX-X	≤0.08	0.5/2.5	≤1.0	10.04	≤0.03	9/11	18/21	8xC/1.0	---

15-2. Ferrite Content

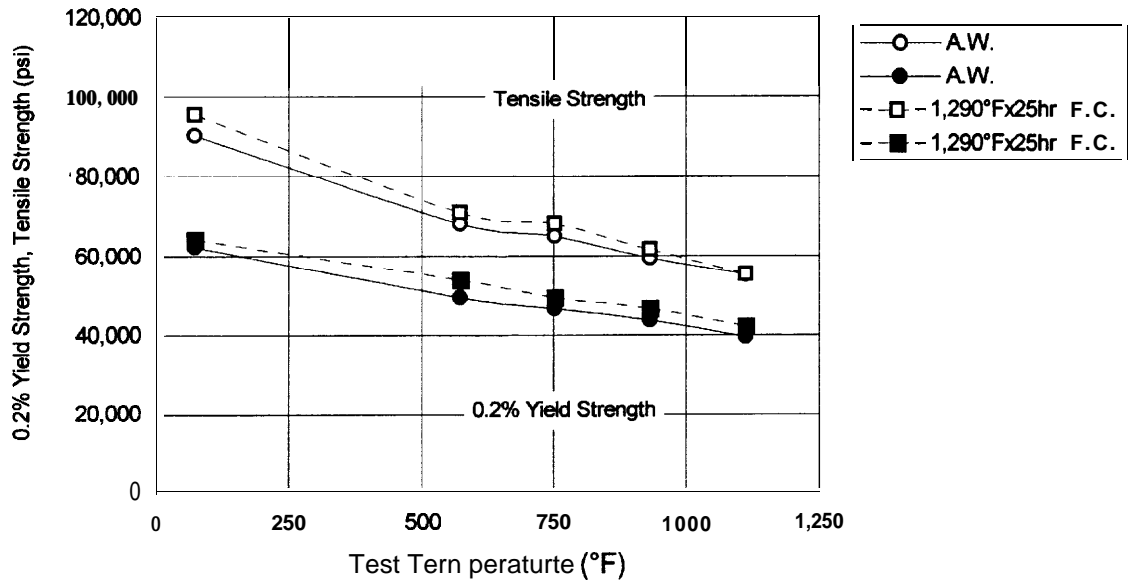
	Shaeffler Diagram (%)	Delong Diagram (FN)	1992-WRC Diagram (FN)
As Welded	6.5	9.1	8.5

15-3. Tensile Test

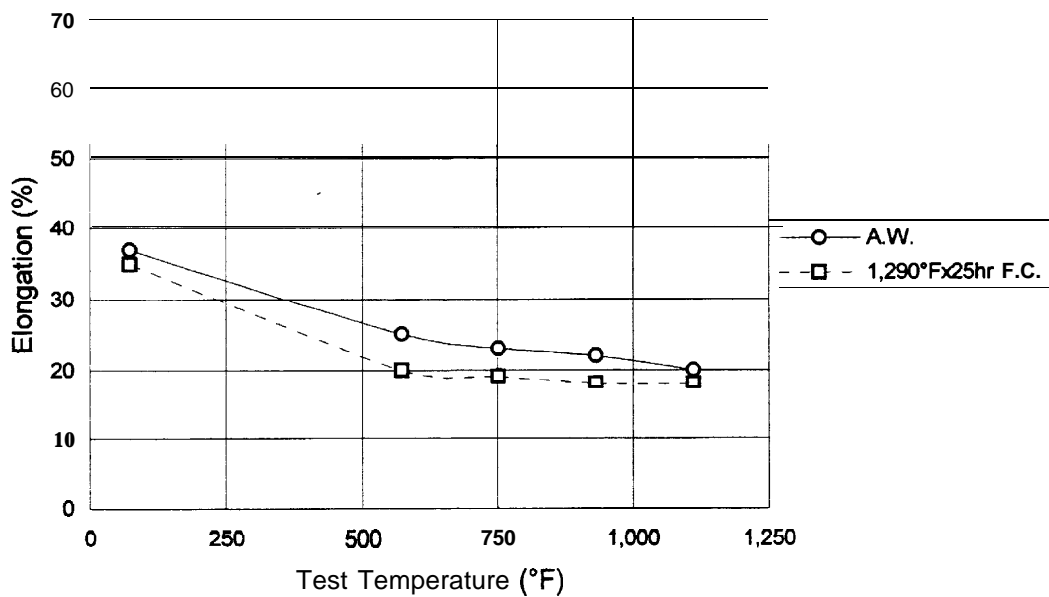
	0.2% Yield Strength (psi)	Tensile Strength (psi)	Elongation (%)	Reduction of Area (%)
DW-347	62,269	81,400	37	53
E347TX-X	---	≥75,000	≥30	---

Note: Test was completed in the as-welded condition at room temperature.

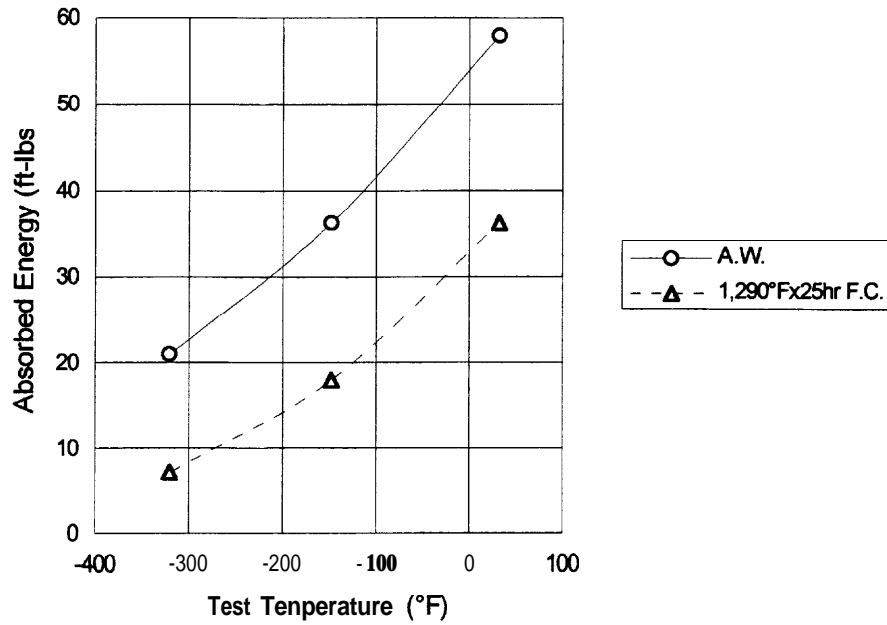
15-4. Tensile Strength and 0.2% Yield Strength



Elongation



15-5. Impact Test



15-6. Corrosion Test

Copper Sulfate Sulfuric Acid Test

PWHT : 1,200°F x 2hr A.C.

Bend Test Results : No Defect