



# UNITED STATES WELDING CORPORATION

<b>USW ALLOY DESIGNATION AND DESCRIPTION</b>	<b>TURBALOY® 347</b> HQ-GRADE GTAW SOLID BARE WELDING WIRE IRON BASE	<b>ISSUED</b> JANUARY 2007	<b>DATA SHEET</b>  <b>5680</b> (8)																																				
		<b>REVISION NO.</b> A																																					
<b>CROSS-REFERENCE CONFORMANCE SPECIFICATIONS</b>	18/8 (Cb) Stainless AMS 5680 & AMS 5790 MSRR6677	18.5Cr 11Ni 0.40Cb USWC 5680 (A) UNS S34781																																					
<b>METALLURGICAL BACKGROUND INFORMATION</b>	<p>TURBALOY® 347 undergoes a series of proprietary abrading and cleaning processes to remove all surface contaminants. These manufacturing processes ensure a consistent ultra-clean weld wire surface.</p> <p>TURBALOY® 347 is an austenitic stainless steel, stabilized with Columbium and containing a small consistent amount of delta ferrite and is used to weld stabilized and/or low carbon stainless alloys of similar composition.</p>																																						
<b>MATERIALS TO BE WELDED AND APPLICATIONS</b>	<p>MSRR 6522, 6523, 6524, 6525, 6527. S126, S127, S128, 2S129, 2S130. AMS 5510, 5570, 5576, 5559, 5512, 5575, 5654. Manufacture and overhaul of gas turbine thin gauge components on 321 and 347 base alloys. Hot gas ducting and liners. To minimize hot cracking susceptibility, apply small stringer beads with convex profile using argon gas shielding, ultra clean conditions and minimum heat input.</p>																																						
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<b>PACKAGING</b>	Sealed polyethylene envelopes. (Desiccants optional)																																						

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