


347 Si Tig

CATEGORY	GMAW-GTAW Solid wires						
TYPE	Filler metal for welding stabilized stainless austenitic steels that are exposed to working temperatures up to 400°C						
APPLICATIONS	For welding stainless austenitic steels that are exposed to working temperatures up to 400°C.						
PROPERTIES	The weld deposit is scale-resistant up to approx. 800°C in normal atmosphere and oxidizing gases. The weld deposit is capable of taking a high polish. Structure: Austenite with delta ferrite						
CLASSIFICATION	AWS	A 5.9: ER 347 Si					
	EN ISO	14343-A: W 19 9 Nb Si					
	DIN: W.Nr.	1.4551					
	DIN	8556: SG X5CrNiNb 19 9					
SUITABLE FOR	1.4541	X 6 CrNiTi 18 10	1.4301	X 5 CrNi 18 10			
	1.4550	X 6 CrNiNb 18 10	1.4303	X 5 CrNi 18 12			
	1.4552	G-X 5 CrNiNb 18 9	1.4308	G-X 6 CrNi 18 9			
	1.4319	X 5 CrNi 18 7	1.4310	X 12 CrNi 17 7			
	1.4306	X 2 CrNi 19 11	1.4312	G-X 10 CrNi 18 8			
	1.4306	G-X 2 CrNi 18 9	-	-			
	AISI: 321, 347						
APPROVALS	TUV (12392.00), CE approved						
WELDING POSITIONS:							
WELD DEPOSIT WEIGHT % (TYPICAL)							
C	Mn	Si	Cr	Ni	Mo	Nb+Ta	
0.04	1.9	0.7	19.5	10	-	min 12x%C. max1,1	
MECHANICAL PROPERTIES							
Heat Treatment	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	20°C	Impact Energy (J) ISO-V -40°C -196°C		Hardness HRC / HV
AW	390	590	30	80	40		
AW: as welded							
WELDING PARAMETERS / PACKING							
Welding Parameters				Packing (kg)			
D (mm)	Current (A) DC-			single	master		
1.6 x 1000	50-80			5	25		
2.0 x 1000	70-110			5	25		
2.4 x 1000	110-180			5	25		
3.2 x 1000	150-250			5	25		
REDRYING TEMPERATURE	not required						
GAS ACC. EN ISO 14175:	I1						