

347 Si

CATEGORY	GMAW-GTAW Solid wires
TYPE	Solid Niobium stabilized stainless steel welding wire
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: G 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 (12393.00), 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 (%)	Impact Energy (J) ISO-V			Hardness HRC / HV
				20°C	-40°C	-196°C	
AW	390	590	30	80		40	

AW: as welded

WELDING PARAMETERS / PACKING					
Welding Parameters			Packing		
D (mm)	Voltage (V)	Current (A) DC+	spool type	kg / spool / Drum	kg / pallet
0,8	15-24	55-160	D-200 / K-300 / drum	5 / 15 / 250	1000 / 1080 / 1000
1,0	15-28	80-240	D-200 / K-300 / drum	5 / 15 / 250	1000 / 1080 / 1000
1,2	15-29	100-300	D-200 / K-300 / drum	5 / 15 / 250	1000 / 1080 / 1000

REDRYING TEMPERATURE	not required
-----------------------------	--------------

GAS ACC. EN ISO 14175:	M12, M13
-------------------------------	----------