

ER347

AWS A5.9 ER347

EN ISO 14343-A : W 19 9 Nb

Description:

A stainless steel gas shielded welding wire designed for all position welding, offers better corrosion resistance than Type 308 wires, used to weld 347 and 321 stainless steel . Niobium (Nb) is used as the stabilized element to prevent intergranular corrosion.

Application:

Used to weld important anti-corrosion steel which contain Nb or nickel-chrome alloys which Ti as the stabilized element .

Diameters: 0.8mm,0.9mm,1.0mm,1.2mm.

Typical Mechanical Properties:

Tensile strength(MPa):	610
Yield strength(MPa):	410
Elongation(%):	42

Typical Chemical Compositon:

C	Mn	P	S	Si	Ni	Cr	Mo	Cu
0.035	1.3	0.012	0.008	0.40	10.0	20.0	0.02	0.015

Welding Current:(DC+)

Diameter(mm)	0,8	0,9	1,0	1,2
Current/A	55-160	65-220	80-240	100-300
Voltage/V	15-24	15-28	15-28	15-29

Note:

- 1.Rusty, oil stains, water and other impurity on the weld parts must be cleaned before welding.
- 2.Shield Gas:Ar+0,5-5%CO₂ or Ar+0,5-3%O₂.
- 3.Gas speed:20-25L/Min
- 4.DC+ connection; Arc length:4-6mm.

5. Tig rods ER347 1,6mm, 2,0mm, 2,4mm, 3,2mm available