

## Filler rod and wire

<b>Features:</b>	▪ Suitable for 18%Cr-8%Ni-Nb and 18%Cr-8%Ni-Ti steel
<b>Classification:</b>	AWS A5.9 ER347
<b>Shielding gas:</b>	Ar
<b>Identification color:</b>	1st Blue
<b>Polarity:</b>	DCEN

## Packaging data

φ mm	Spool		Tube	
	kg	kg	Length mm	g/piece
1.0	10	-	-	-
1.2	10	5	1,000	9
1.6	10	5	1,000	16
2.0	-	5	1,000	25
2.4	-	5	1,000	36
3.2	-	5	1,000	64
<b>Volume mm</b>	240W, 110H, 240L		40W, 35H, 1015L	

## Composition (rod and wire mass%)

	Typical	Guaranty <sup>a</sup>
<b>C</b>	0.05	0.08
<b>Si</b>	0.40	0.30~0.65
<b>Mn</b>	2.1	1.0~2.5
<b>P</b>	0.02	0.03
<b>S</b>	0.01	0.03
<b>Ni</b>	10.0	9.0~11.0
<b>Cr</b>	19.3	19.0~21.5
<b>Mo</b>	0.07	0.75
<b>Cu</b>	0.07	0.75
<b>Nb</b>	0.6	10xC~1.0

Note: <sup>a</sup> Single values are maximum.

## Welding parameters (A)

φ mm	
1.0	50~80
1.2	50~100
1.6	100~200
2.0	100~200
2.4	150~250
3.2	200~300

## All-weld mechanical properties

	Typical
<b>0.2%YS (MPa)</b>	460
<b>TS (MPa)</b>	630
<b>El on 4d (%)</b>	38
<b>IV 0°C (J)</b>	88

## Approvals

NK	KY347
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