

## 347 Si

<b>CATEGORY</b>	GMAW-GTAW Solid wires																																									
<b>TYPE</b>	Solid Niobium stabilized stainless steel welding wire																																									
<b>APPLICATIONS</b>	For welding stainless austenitic steels that are exposed to working temperatures up to 400°C.																																									
<b>PROPERTIES</b>	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																																									
<b>CLASSIFICATION</b>	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																																								
<b>SUITABLE FOR</b>	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																																									
<b>APPROVALS</b>	TUV (12393.00), CE approved																																									
<b>WELDING POSITIONS:</b>																																										
<b>WELD DEPOSIT WEIGHT % (TYPICAL)</b>	<table border="1"> <thead> <tr> <th>C</th> <th>Mn</th> <th>Si</th> <th>Cr</th> <th>Ni</th> <th>Mo</th> <th>Nb+Ta</th> </tr> </thead> <tbody> <tr> <td>0.04</td> <td>1.9</td> <td>0.7</td> <td>19.5</td> <td>10</td> <td>-</td> <td>min 12x%C. max1,1</td> </tr> </tbody> </table>						C	Mn	Si	Cr	Ni	Mo	Nb+Ta	0.04	1.9	0.7	19.5	10	-	min 12x%C. max1,1																						
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<b>REDRYING TEMPERATURE</b>	not required																																									
<b>GAS ACC. EN ISO 14175:</b>	M12, M13																																									