

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.
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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
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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
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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	Rp0,2 (N/mm ²)	Rm (N/mm ²)	A5 (%)	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					
D (mm)	Welding Parameters			Packing (kg)	
	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
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GAS ACC. EN ISO 14175:	I1
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