SUBARC 347Si

Used to weld titanium and niobium stabilised 18/8 stainless steel types 321 and 347. Service temperatures are typically –100°C to about 400°C. Applications are similar to 308L and include food, brewery, pharmaceutical equipment, architectural, general fabrication and nuclear engineering.

CLASSIFICATIONS

AWS	A5.9	ER347
BS	EN 12072	19 9 Nb
DIN	8556	SG X5CrNiNb 19 9 (1.4551)

CHEMICAL ANALYSIS

% Carbon	<0.04	**% Nickel**	9.700
% Manganese	1.500	**% Molybdenum**	0.200
% Silicon	0.400	**%Niobium**	0.600
% Sulphur	0.005	**% Copper**	0.100
% Phosphorus	0.020	**% Ferrite**	8.000
% Chromium	19.50		

TYPICAL MECHANICAL PROPERTIES ALL WELD METAL

Tensile Strength	570 MPa
0.2% Proof Stress	450 MPa
Elongation on 4d	41%
Impact Energy -20°C	100J

* Flux Dependant

Microstructure
Austenite with a controlled level of ferrite, normally in the range 3-12FN.

PACKING DATA

SAW Wire (DC+)

Diameter (mm)	Current		Item Number	Pack Mass (Kg)
	Amps	Volts		
3.20	400	32	078-168	25
4.00	450	33	078-170	25

Suggested flux : Afrox Flux MH or DX-9

For more information contact the Afrox Customer Service Centre,
tel: 0860 020202 or e-mail: customer.service@afrox.boc.com
Website: www.afrox.com

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