

**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**

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

**Microstructure**

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

\* Flux Dependant

**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

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