

MIG / TIG 347



MIG/TIG 347 is used to weld titanium and niobium stabilised 18/8 stainless steel types 321 and 347. Also suitable for unstabilised grades such as 304/304L. Service temperatures are typically -100°C to approximately 400°C. Applications are similar to 308L and include food, brewery, pharmaceutical

equipment, architectural, general fabrication and nuclear engineering. The 347 consumables covered here are generally not suitable for service in elevated temperature structural applications where 0.04-0.08% carbon is specified for creep resistance.

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	660 MPa
0.2% Proof Stress	450 MPa
Elongation on 4d	42%
Impact Energy -20°C	100J

Microstructure

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

PACKING DATA

MIG (DC+)

Diameter (mm)	Current		Item Number	Pack Mass (Kg)
	Amps	Volts		
0.80	120	19	033-097	15
1.20	180	28	033-100	15

TIG (DC-)

Diameter (mm)	Current		Item Number	Pack Mass (Kg)
	Amps	Volts		
1.60	100	12	030-461	5
2.00	100	12	030-462	5
2.40	100	12	030-463	5
2.40	100	12	030-464	5

Suggested gas for welding : Stainshield Plus, Stainshield (MIG), Argon (TIG)

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