



MIGINOX 347

GMAW STAINLESS STEEL

AWS A/SFA 5.9 **ER347**

CLASSIFICATION:

EN ISO 14343-A

G 19 9 Nb

IS 5856

ES 20.10 Nb

KEY FEATURES:

- 19Cr/9Ni/Nb type stabilized stainless steel wire
- Resistance to intergranular corrosion and scaling up to 850°C
- Resistance to cracking and embrittlement
- Smooth operating characteristics
- Radiographic quality welds

APPROVALS: CE

TYPICAL APPLICATIONS:

- Welding stabilized Cr-Ni steels such as AISI 321, 321H, 347, 347H
- Refineries, power plants, centrifugal pump impellers and shafts, valve faces, seats
- Recommended for use at high temperatures
- Fabrication of boiler and gas turbine
- Welding of stainless steel tanks, valves, pipes in food, chemical and petrochemical industries



TYPICAL CHEMICAL COMPOSITION OF BARE SOLID WIRE, Wt %:

C	Mn	Si	Cr	Ni	Nb
0.04	1.9	0.4	19.7	9.5	0.5

MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	EL%
Typical	As Welded	580	36

PARAMETERS - PACKING DATA:

Ø, mm	Kg/Spool		
0.8	12.5	 DCEP STORAGE / HANDLING : Keep dry and follow handling instructions mentioned on the box	All Positions 
1.2	12.5		
1.6	12.5		

Shielding Gas	Gas Flow Rate, LPM
98Ar/2O ₂ or Ar/1-5CO ₂	15-25