

## MIGWELD 347Si

MIG/MAG Wires [GMAW]

Stainless and high alloyed steels

CLASSIFICATION:	APPROVALS:	APPLICATION:
EN ISO 14343-A : G 19 9 Nb Si DIN 8556 : S-GX5 CrNiNb19 9 AWS A-5.9 : ER 347 Si W.Nr. : 1.4551		Power generation industry Constructions & Engineering Metallurgy (Steelworks) Petrochemical and chemical industry

- Stabilized solid wire for welding corrosion-resistant single-grade stainless steels up to 400°C.
- Oxidation-resistant alloy up to a temperature of 800°C.

### Application

For proper welding of 304, 304L and similar steels stabilized with titanium. Nitric acid processing components, acetic acid production, food and dairy industry, oil and gas industry, expansion joints, exhaust manifolds, chemical industry, flanges, valves, valve systems.

### Base material



PN	DIN	W.Nr.	AISI/ASTM
0H18N9	X5 CrNi 18 10	1.4301	304
0H18N10T, 1H18N9T, 1H18N10MT	X6 CrNiTi 18 10	1.4541	321
0H18N12Nb	X6 CrNiNb 18 10	1.4550	347
	G-X6CrNi 18 9	1.4308	CF-8
	G-X5CrNiNb 18 9	1.4552	CF-8C
	G-X10CrNi 18 8	1.4312	A157, 305
	X10 CrNiNb18 10	1.6905	
	X7 CrAl13	1.4002	405
	X10 Cr13	1.4006	410
H17	X8 Cr17	1.4016	430
	X15 Cr13	1.4024	410/420
	X20 Cr13	1.4021	420
0H17T	X8 CrTi17	1.4510	430Ti
	X8 CrNb17	1.4511	430Ti
	X5 CrTi12	1.4512	409
	X2 CrNi19 11	1.4306	304L
	X5 CrNiNb18 9	1.4543	347
	X5 CrNi18 12	1.4303	305, 308
	X12 CrNi17 7	1.4310	301
	X5 CrNi17 8	1.4319	301L
	G-X2 CrNi18 9	1.4306	304L

### Typical chemical composition %

C	Si	Mn	Cr	Ni	Nb
0,06	0,70	2,00	19,00	9,00	0,70

### Typical mechanical properties

Yield strength Re [N/mm <sup>2</sup> ]	>350
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<b>Tensile strength Rm [N/mm<sup>2</sup>]</b>	570-670
<b>Elongation A5 [%]</b>	>30
<b>Impact energy Kv [J]</b>	>60J (20°C) /
<b>Wire/rod type</b>	Solid
<b>Welding current</b>	
<b>Welding positions</b>	
<b>Shielding gases acc. to EN ISO 14175</b>	I1 - Ar / M12 - Ar + 0.5 - 5% CO <sub>2</sub> / M13 - Ar + 0.5 - 3% O <sub>2</sub> /

#### Welding parameters and packing

∅	Welding current [A]	Voltage [V]	Weight of packet [kg]
0,8	100-160	18-22	15,0
1,0	140-200	18-24	15,0
1,2	170-260	20-28	15,0
1,6	220-350	24-36	15,0

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