TIGWELD 347Si

TIG Rods [GTAW]

Stainless and high alloyed steels

CLASSIFICATION:	APPROVALS:	APPLICATION:
EN ISO 14343-A : W 19 9 Nb Si DIN 8556 : SG-X5 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 wire for welding corrosion-resistant 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, petroleum industry, expansion joints, exhaust manifolds, chemical industry, flanges, valves, valve systems.

Base material

AISI/ASTM	DIN	W.Nr.	PN
304	X5 CrNi 18 10	1.4301	0H18N9
321	X6 CrNiTi 18 10	1.4541	0H18N10T, 1H18N9T, 1H18N10MT
347	X6 CrNiNb 18 10	1.4550	0H18N12Nb
	G-X6CrNi 18 9	1.4308	
	G-X5CrNiNb 18 9	1.4552	
A157, 305	G-X10CrNi 18 8	1.4312	
	X10 CrNiNb18 10	1.6905	
405	X7 CrAl13	1.4002	
410	X10 Cr13	1.4006	
430	X8 Cr17	1.4016	H17
410/420	X15 Cr13	1.4024	
420	X20 Cr13	1.4021	
430Ti	X8 CrTi17	1.4510	0H17T
430Ti	X8 CrNb17	1.4511	
409	X5 CrTi12	1.4512	

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/mm2]	>350
Tensile strength Rm [N/mm2]	570-670
Elongation A5 [%]	>30
Impact energy Kv [J]	>60J (20°C) /
Wire/rod type	solid

	
Welding positions	
Shielding gases acc. to EN ISO 14175	I1 - Ar / I3 - Ar + >0-95% He /

Welding parameters and packing

ø	Length [mm]	Weight of packet [kg]
1,6	1000 /	5,0
2,0	1000 /	5,0
2,4	1000 /	5,0
3,2	1000 /	5,0

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