

ES TIG 347

GTAW

ER347

ESWECO
The Art of Welding

Description

Bare, corrosion-resistant, chromium-nickel rods for welding stabilised austenitic chromium-nickel alloys of the 18% Cr-8% Ni type.

The rods are stabilised with niobium, which provides good resistance to the intergranular corrosion of the weld metal. Due to the niobium content, this alloy is recommended for use at higher temperatures.

Current

DC (-)

Classifications

EN 12072	W 19 9 Nb
SFA/AWS A5.9	ER347
Werkstoffnummer	~1.4551

Typical all weld metal composition, %

C	Si	Mn	Cr	Ni	Mo	Nb	Cu
<0.08	0.5	1.4	20.0	10.0	<0.3	<0.1	<0.3

Typical mech. Properties all weld metal

Yield stress, MPa	>350
Tensile strength, MPa	>550
Elongation, %	>25

Charpy V

Test temps, °C	Impact values, J
-20	90

Welding parameters

Diameter, mm	Length, mm	Weight of rods/box, kg
1.6	1000	5.0
2.0	1000	5.0
2.4	1000	5.0
3.2	1000	5.0