ROYAL ER 347 (ER 347)

AWS –SFA A 5.9 ER 347 EN ISO 14343 A G/W 19 9 Nb

Applications

This austenitic stainless steel wire is used for welding AISI steels 321 and 347, it is used 18/8 steels stabilized with Titanium or Niobium, in the manufacturing of equipments for chemical, food and aircraft industries, also used for welding of gas turbines and soap industries.

Characteristics on Usage

This type of filler rods are usually used for welding Chromium-Nickel alloys of similar composition, stabilized with Columbium or Titanium. These elements are almost equally effective in stabilizing carbon and in providing high temperature strength. The weld metal is highly resistance to cracking, corrosion and high temperature upto 800 °C, gives radiography quality welds and confirms to AWS SFA 5.9 ER 347 class.

Packing

Each Packets content 5 kg of Wire Rods having length 500 mm.,1000mm.

Chemical Composition Of Weld Metal

C%	Mn%	Si%	S%	Cr %	Ni %	Mo %	N%
0.080 Max	1.0 - 2.5	0.30 - 0.65	0.030 Max	19.0 - 21.5	9.0 - 11.0	0.75 Max	0.60 Max

Mechanical Properties Of Weld Metal

U.T.S. (N/mm^2)	ELONGATION (L = 4d) %
520 Min	30 % Min