

TI 347

TIG Welding Wire - Stainless Steels

Standards

AWS/ASME SFA - 5.9	ER347
EN ISO 14343 - A	W 19 9 Nb
TS EN ISO 14343 - A	W 19 9 Nb
DIN M. No.	1.4551

Applications

Stabilized austenitic stainless steel welding rod for GTA (TIG) welding of unstabilized and stabilized corrosion resisting Cr-Ni steels, used in food, beverage, chemical and pharmaceutical industries. Stabilized with Nb (Niobium) and resistant to intergranular corrosion. Weld metal is suitable for operating temperatures of up to +400°C, non-scaling up to +800°C, in air and oxidizing combustion gases.

Materials

EN	Material	ASTM
X5CrNi18-10	1.4301	304
X4CrNi18-12	1.4303	305
X2CrNi19-11	1.4306	304L
GX5CrNi19 10	1.4308	CF-8
X6CrNiTi18-10	1.4541	321
X6CrNiNb18-10	1.4550	347, 347H
GX5CrNiNb19-11	1.4552	
X8CrNiTi18-10	1.4878	321H

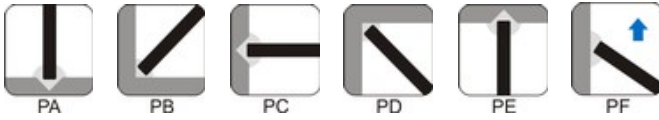
Typical Mechanical Values of Weld Metal

Test Condition	Protection Gas	Akma Dayanımı (N/mm ²)	Tensile Strength (N/mm ²)	Elongation A5 (%)	Charpy V-Notch Properties (J)
As welded	I1	> 350	570 - 670	> 30	20°C → 65

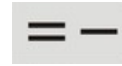
* Kimyasal kompozisyon ve mekanik özellikler EN ISO 14175 - I1 (%100 Ar) koruyucu gazının kullanılması durumunda geçerlidir.

Application Information

Welding Positions



Polarity:



Protection Gas:

I1

Welding Parameters & Efficiency

Diameter x Length (mm)

1.60x1000

2.00x1000

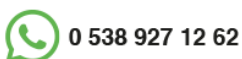
2.40x1000

3.20x1000

Packaging Information

Product Code	Diameter x Length (mm)	Quantity per Box	Box Gross Weight (Kg)	Boxes per Outer Box	Outer Box Gross Weight (Kg)	Packaging Type
2313908M15	1.60x1000	5 KG	5.30	4	21.40	Cardboard Tube
2313910M15	2.00x1000	5 KG	5.30	4	21.40	Cardboard Tube
2313911M15	2.40x1000	5 KG	5.30	4	21.40	Cardboard Tube
2313914M15	3.20x1000	5 KG	5.30	4	21.40	Cardboard Tube

Storage & Re-Drying Information



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