

## CLASSIFICATIONS

EN ISO 14343-A : G 19 9 Nb Si

AWS A5.9 : ER 347 Si

## DESCRIPTION

- Used for the welding of 13% Cr steels which are used in the textile, paper, paint and food industries
- Resistant to corrosion up to +400°C, suitable for MIG welding
- Ar+ %2.5 O<sub>2</sub> or Ar+ %2.5 CO<sub>2</sub> mixed gases are used for shielding, also used for the welding of materials which have the similar chemical composition to welding wire

## CHEMICAL ANALYSIS OF WELD METAL % (TYPICAL)

C: 0.035 | Si: 0.9 | Mn: 1.2 | Cr: 19.4 | Ni: 9.7 | Nb: +

## MECHANICAL PROPERTIES

Yield Strength (MPa)	Tensile Strength (MPa)	Impact Strength (ISO-V/+20°C)	Elongation (L <sub>0</sub> =5d <sub>0</sub> ) (%)
min. 400	570- 710	min. 63 J	min. 30

## BASE MATERIALS

- X6 CrNiNb 18 10, X6 CrNiTi 18 10, G-X5 CrNiNb 18 9, X5 CrNi 18 10, G-X 10 CrNi 18 8, X12 CrNiTi 18 9, X10 CrNiNb 18 10
- AISI & ASTM: 304, 321, 347, A157Gr.C9, A296Gr.CF8C, A320Gr.B8C, A320Gr.B8D

## WELDING POSITIONS



## CURRENT CONDITION

MIG D.C.(+)

## OPERATING DATA

Product Code	Diameter x Length (mm) / (inch)		Weight (Kg)	Package Type
1011100065	1.0	0.040"	15	BS 300
1011100066	1.2	0.047"	15	BS 300