

### CLASSIFICATIONS

EN ISO 14343-A : W 19 9 Nb

AWS A5.9 : ER 347

### 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 TIG welding
- Argon is the shielding gas and it is 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: 0.5 | Mn: 1.4 | Cr: 19.4 | Ni: 9.5 | Nb: +

### MECHANICAL PROPERTIES

Yield Strength (MPa)	Tensile Strength (MPa)	Impact Strength (ISO-V/+20°C)	Elongation (L <sub>o</sub> =5d <sub>o</sub> ) (%)
min. 430	600 - 740	min. 63 J	min. 30

### BASE MATERIALS

- X6 CrNiNb 18 10, X6 CrNiTi 18 10, G-X5 CrNiNb 18 9, X-5 CrNi 18 10, G-X10 CrNi 18 8, X12 CrNiTi 18 9, X10 CrNiNb 1810
- AISI & ASTM: 304, 321, 347, A157Gr.C9, A296Gr.CF8C, A320Gr.B8C, A320Gr.B8D

### WELDING POSITIONS



### CURRENT CONDITION

TIG D.C.(-)

### OPERATING DATA

Product Code	Diameter x Length (mm) / (inch)		Weight (Kg)	Package Type
1011100061	1.6 x 1000	1/16 x 39"	5	Plastic Box
1011100062	2.0 x 1000	5/64 x 39"	5	Plastic Box
1011100063	2.4 x 1000	3/32 x 39"	5	Plastic Box
1011100064	3.2 x 1000	1/8 x 39 "	5	Plastic Box