

❖ Product Description

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| I. The wire with 19Cr-9Ni-Nb type stabilized stainless steel wire | III. Resistant to cracking and embrittlement |
| II. The weld metal is good in resistance to intergranular corrosion and scaling up to 850°C | IV. It has smooth operating characteristics |
| | V. Radiographic weld quality |

❖ Range of Application

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| I. Good for welding stabilized Cr-Ni steels such as AISI 321, 321H, 347, 347H | III. Suitable for working at high temperatures |
| II. Excellent application in refineries, power plants, centrifugal pump impellers and shafts, valve faces, seats | IV. For fabrication of boiler and gas turbine |
| | V. Suitable for welding of stainless steel tanks, valves pipe in food, chemical and petrochemical industries |

❖ Classification

- AWS/SFA 5.9 ER347

❖ Chemical Composition

Type of Wire		C	Mn	Si	S	P	Cr	Ni	Mo	Cu	Nb
ER347	Min	-	1.0	0.30	-	-	19.0	9.0	1.0	-	10xCmin
	Max	0.08	2.5	0.65	0.03	0.03	21.5	11.0	2.5	0.75	1.0

❖ Wire Size & Weld Position

- Diameter in mm-1.6, 2.0 2.40,3.20,4.00 and 5.00.
- All position

❖ Current and Gas- Flow Rate

- DCEN & 8-15 lit/min

❖ Packaging

Sizes available in cut length of 1000mm	1.60,2.00,2.40,3.20,4.00,5.00			
Packing Code	A		B	
Packing Available	5kg PLASTIC TUBE	20KG BOX	10KG PAPER TUBE	20KG BOX
Net Weight of Wire	5	20	10	20

Special Note: -

All the value above mentioned are typical values.

- (1) All the value above mentioned are typical values
- (2) Usually all chemistry and mechanical properties will depend on actual wire chemistry and arc voltage used for welding.

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