



**GMAW / GTAW STAINLESS STEEL**  
**MIGINOX 347Si**

347Si TYPE STAINLESS STEEL SOLID WIRE



**CLASSIFICATION :** EN ISO 14343-A    AWS A/SFA 5.9    **APPROVALS :**

G 19 9 NbSi

ER347Si

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**KEY FEATURES :**

- 19Cr/9Ni type Nb stabilized stainless steel solid wire
- High Si content improves wetting characteristics
- Resistance to cracking and embrittlement
- Resistance to intergranular corrosion and scaling up to 850°C
- Smooth operating characteristics
- Radiographic quality welds

**WELDING POSITION :**



**DCEP**

Shielding Gas	Gas Flow Rate, LPM	Stickout, mm
98Ar/2O <sub>2</sub> or Ar/1-5CO <sub>2</sub>	15-22	10-20

**TYPICAL APPLICATIONS :**

- Welding stabilized Cr-Ni steels such as AISI 321, 321H, 347, 347H
- Refineries, power plants, centrifugal pump Impellers and shafts, valve faces, seats
- Fabrication of boiler and gas turbine
- Welding of stainless steel tanks, valves, pipes in food, chemical and petrochemical industries

**STORAGE / HANDLING :**

Keep dry and follow handling instructions mentioned on the box

**CHEMICAL COMPOSITION OF BARE SOLID WIRE, Wt% :**

	C	Mn	Si	Cr	Ni	Mo	Nb	S	P
Specification	0.08 max	1.0-2.5	0.65-1.0	19.0-21.5	9.0-11.0	0.75 max	10xC-1.0	0.03 max	0.03 max

**MECHANICAL PROPERTIES OF ALL WELD METAL :**

	Condition	UTS, MPa	EL%
Specification	As Welded	520 min	30 min

Mechanical properties will vary with the type of shielding gas used.

**PACKING DATA :**

Ø, mm	Kg/Spool
0.8	12.5
1.2	12.5
1.6	12.5
2.0	12.5