



**GMAW / GTAW STAINLESS STEEL**

**MIGINOX 347 / TIGINOX 347**

Nb STABILIZED STAINLESS STEEL ALLOY FOR HIGHEST RESISTANCE AGAINST INTERGRANULAR CORROSION



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

Miginox 347: G 19 9 Nb      ER347  
Tiginox 347: W 19 9 Nb      ER347

**KEY FEATURES :**

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

**WELDING POSITION :**



**GMAW: DCEP**  
**GTAW: DCEN**

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

**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
- Recommended for use at high temperatures
- 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	0.30-0.65	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 :**

Miginox 347	Ø, mm		Kg/Spool	
	0.8		12.5	
	1.2		12.5	
	1.6		12.5	
	2.0		12.5	
Tiginox 347	Ø x L, mm	Primary Box, Kg	No. of Primary Boxes	Net Wt. of Carton, Kg
	1.6 x 1000	5	4	20
	2.0 x 1000	5	4	20
	2.5 x 1000	5	4	20

**EQUIVALENT :**

SMAW Electrode: **Superinox 1B**

FCAW Wire: **Miginox FC 347**