



347Si XM

AWS A 5.9: ER347Si ISO 14343-A: G 19 9 Nb Si

DESCRIPTION

Austenitic stainless alloy with Niobium addition for welding of 321-steels like SS2337 and 18/8-steels exposed to higher temperatures between 400-850 °C.

WELDING POSITIONS



CURRENT

DC+

GAS

Ar / Co₂

BASE MATERIALS

Stainless and austenitic stainless steels
1.4541, 1.4550

MECHANICAL PROPERTIES

<i>R_m</i> (Mpa)	<i>R_{p 0,2}</i> (Mpa)	<i>A₅</i> (%)	<i>KV(j)</i>
630	460	33	+20°C – 110 -196°C – 30

WELD METAL COMPOSITION(%)

C	Mn	Si	Cr	Mo	Ni	Nb
0,03	1,5	0,8	19,5	0,2	9,8	0,5

PACKAGING

Dimension(mm)	0,8	1,0	1,2	
Spool size(kg)	15	15	15	
Item code	9M34708251	9M34710251	9M34712251	
Wire feeding/min	3,4-11	2,9-8,4	4,9-8,5	
Ampere (A)	50-140	80-190	180-280	
Volt (V)	16-22	16-24	20-28	

EQUIVALENT FILLER METALS

MMA	Meltolit 347 E
TIG	Meltolit 347Si XT
FCW	Meltolit 347 FCW