

Classifications

EN ISO 14343-A	EN ISO 14343-B	AWS A5.9
G 19 9 Nb Si	SS347Si	ER347Si

Characteristics and typical fields of application

GMAW wire of type G 19 9 Nb Si / ER347Si designed for first class welding, good wetting and feeding characteristics as well as reliable corrosion resistance up to +400 °C.

Low temperature service down to -196 °C.

Base materials

1.4550 X6CrNiNb18-10, 1.4541 X6CrNiTi18-10, 1.4552 GX5CrNiNb19-11, 1.4301 X5CrNi18-10, 1.4312 GX10CrNi18-8, 1.4546 X5CrNiNb18-10, 1.4311 X2CrNi18-10, 1.4306 X2CrNi19-11
AISI 347, 321, 302, 304, 304L, 304LN; ASTM A296 Gr. CF 8 C, A157 Gr. C9, A320 Gr. B8C or D

Typical analysis of solid wire (wt.-%)

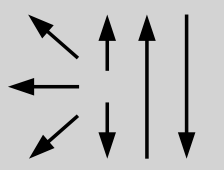
	C	Si	Mn	Cr	Ni	Nb
wt.-%	0.035	0.8	1.3	19.4	9.7	+

Mechanical properties of all-weld metal

Condition	Yield strength R _{p0,2}	Tensile strength R _m	Elongation A (L ₀ =5d ₀)	Impact work ISO-V KV J	
	MPa	MPa	%	+20 °C	-196 °C
u	460 (≥ 350)	630 (≥ 550)	33 (≥ 25)	110	≥ 32

u untreated, as welded – shielding gas Ar + 2.5 % CO₂

Operating data

	Polarity: DC (+)	Shielding gases: Argon + max. 2.5 % CO ₂	ø (mm)
			0.8
			1.0
			1.2

Approvals

TÜV (00025.), GL (4550S), LTSS, SEPROZ, CE, NAKS