



Product Data Sheet

W 'Tungsten inert gas arc welding'

OK Tigrod 347

Signed by Mats Linde	Approved by Per-Åke Pettersson/Christos Skodras	Reg no EN005031	Cancelling EN004309	Reg date 2009-11-23	Page 1 (1)
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REASON FOR ISSUE

Shielding Gas standard up date.

GENERAL

Bare corrosion resisting chromium-nickel rods for welding of stabilized austenitic chromium nickel alloys of 18% Cr - 8% Ni-type.

The rods are stabilized with Niobium, which gives a good resistance to intergranular corrosion of the weld metal. Due to the niobium content this alloy is recommended for use at higher temperatures.

Shielding Gas: I1 (EN ISO 14175)

Alloy Type: Austenitic (with approx. 8 % ferrite) 19% Cr - 9% Ni - Nb

CLASSIFICATIONS Wire Electrode

EN ISO 14343 W 19 9 Nb
SFA/AWS A5.9 ER347
Werkstoffnummer ~1.4551

APPROVALS

Not applicable

CHEMICAL COMPOSITION

Wire/Strip (%)

	Min	Max
C		0.08
Si	0.30	0.65
Mn	1.0	1.8
P		0.030
S		0.020
Cr	19.0	21.0
Ni	9.0	11.0
Mo		0.3
Nb		1.0
Cu		0.3
N		0.08
Others tot		0.50

Comments:
Nb: min 12 x C %

MECHANICAL PROPERTIES OF WELD METAL

All Weld Metal

Properties	As welded	
	Min	Typ
Rp0.2 (MPa)	350	510
Rm (MPa)	550	655
A4-A5 (%)	25	35
Charpy V at RT°C (J)		130