



# Product Data Sheet

W 'Tungsten inert gas arc welding'

# OK Tigrod 347Si

Signed by Mats Linde	Approved by Per-Åke Pettersson/Christos Skodras	Reg no EN005029	Cancelling EN004164	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 austenitic chromium nickel alloys of 18 % Cr-8 % Ni-type.

OK Tigrod 347Si has a good general corrosion resistance. The alloy is stabilized with Niobium to improve the resistance against intergranular corrosion of the weld metal. The higher silicon content improves the welding properties, such as wetting. 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 NbSi  
SFA/AWS A5.9      ER347Si  
Werkstoffnummer    ~1.4551

## APPROVALS

VdTÜV      09736

## CHEMICAL COMPOSITION

	All Weld Metal (%)	Wire/Strip (%)	
	Nom	Min	Max
C	0.04		0.08
Si	0.8	0.65	1.00
Mn	1.5	1.0	2.5
P	0.02		0.030
S	0.01		0.020
Cr	20	19.0	21.0
Ni	10	9.0	11.0
Mo	0.1		0.3
Nb	0.7		1.0
Cu	0.1		0.3
N			0.08
Others tot			0.50

## MECHANICAL PROPERTIES OF WELD METAL

Properties	All Weld Metal	
	Min	Typ
Rp0.2 (MPa)	350	440
Rm (MPa)	550	640
A4-A5 (%)	25	35
Charpy V at 20°C (J)		90