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Per-Ake Bjornstedt	P-O Oskarsson	Per-Ake Bjornstedt	EN008914	EN008303	2020-01-21	1 (2)

## REASON FOR ISSUE

Product name changed from Sandvik to Exaton.

## GENERAL

Filler metal 19.9.Nb is suitable for joining stainless steels of the 18Cr/8Ni/Nb and 18Cr/8Ni/Ti types. Due to the strengthening effect of niobium, this grade is recommended if the weld metal will be exposed to temperatures above 400°C (750°F). It is used for TIG-welding.

## CLASSIFICATIONS Wire Electrode

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

## APPROVALS

CE EN 13479  
 VdTÜV 00068

## CHEMICAL COMPOSITION

### Wire/Strip (%)

	Nom
C	0.03
Si	0.4
Mn	1.3
P	<0.025
S	<0.015
Cr	19.5
Ni	9.5
Mo	<0.3
Co	<0.05
Cu	<0.10
N	<0.07

## MECHANICAL PROPERTIES OF WELD METAL

### All Weld Metal

Properties	As welded
	Typ
Rp0.2 (MPa)	400
Rm (MPa)	610
A5 (%)	42
Z (%)	73
Charpy V at 20°C (J)	150
Charpy V at -196°C (J)	50

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**OTHER DATA**

**CORROSION PROPERTIES:** 19.9.Nb has good resistance to general corrosion and due to its niobium content, good resistance to intercrystalline corrosion.

**RECOMMENDED WELDING DATA:**

The parameters for TIG welding depend largely upon the base metal thickness and the welding application.

Electrode negative and a shielding gas of argon or helium should be used to prevent oxidation of the weld metal.

**WELD METAL CHARACTERISTICS:** The weld metal has an austenitic matrix with a ferrite number of 8-10FN according to the DeLong diagram.

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