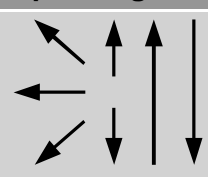


Classifications						
EN ISO 14343-A	EN ISO 14343-B			AWS A5.9		
G 19 9 Nb Si	SS347Si			ER347Si		
Characteristics and typical fields of application						
Solid wire of G 19 9 Nb Si / ER347Si type for welding Ti and Nb-stabilized 1.4541 / 321 and 1.4546 / 347 austenitic stainless steel grades. Designed to produce first class welding, good wetting and feeding characteristics. Max. service temperature 400°C. Low temperature service down to – 196°C. Max. service temperature 400°C.						
Base materials						
1.4301 X5CrNi18-10, 1.4306 X2CrNi19-11, 1.4311 X2CrNi18-9, 1.4312 GX10CrNi18-8, 1.4541 X6CrNiTi18-10, 1.4546 X5CrNiNb18-10, 1.4550 X6CrNiNb18-10, 1.4552 GX5CrNiNb19-11 UNS S30400, S30403, S30453, S32100, S34700 AISI 347, 321,302, 304, 304L, 304LN						
Typical analysis of solid wire						
	C	Si	Mn	Cr	Ni	Nb
wt-%	0.05	0.8	1.5	19.5	9.5	≥ 12xC
Mechanical properties of all-weld metal - typical values (min. values)						
Condition	Yield strength R _{p0.2}	Tensile strength R _m		Elongation A (L ₀ =5d ₀)	Impact values ISO-V CVN J	
	MPa	MPa		%	+20 °C	-196 °C
u	400 (≥ 350)	570 (≥ 550)		30 (≥ 25)	100	45 (≥ 32)
u untreated, as-welded – shielding gas Ar + 2.5% CO ₂						
Operating data						
	Polarity: DC +	Shielding gas: (EN ISO 14175) M12, M13		ø mm 0.8 1.0 1.2	Spool: BS300	
Approvals						
TÜV (00604), DB (43.132.06), CE						