

# LNT 347Si

## CLASSIFICATION

AWS A5.9	ER347Si	A-Nr	8	Mat-Nr	1.4551
ISO 14343-A	W 19 9 NbSi	F-Nr	6		
		9606 FM	5		

## GENERAL DESCRIPTION

Solid rod for welding Ti or Nb stabilized stainless CrNi-steels  
High resistance to intergranular corrosion and oxidizing environments

## SHIELDING GASES (ACC. ISO 14175)

It Inert gas Ar (100%)

## APPROVALS

TÜV	CE	DB
+	+	+

## CHEMICAL COMPOSITION (W%) TYPICAL WIRE

C	Mn	Si	Cr	Ni	Mo	Nb
0.05	1.4	0.7	19.5	9.5	0.01	0.6

## MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Shielding gas	Condition	0.2% proof strength	Tensile strength	Elongation	Impact ISO-V(J)	
			[N/mm <sup>2</sup> ]	[N/mm <sup>2</sup> ]	[%]	+20°C	-196°C
Typical values	It	AW	400	650	35	80	45

## EXAMPLES OF MATERIALS TO BE WELDED

Steel grades	EN 10088-1/-2	EN 10213-4	Mat. Nr	ASTM/ACI A240/A312/A351	UNS
<b>Ti-,Nb stabilized</b>					
	X6CrNiTi18-10		1.4541	(TP)321 (TP)321H	S32100 S32109
	X6CrNiNb18-10		1.4550	(TP)347 (TP)347h	S34700 S34709
		G-X5CrNiNb19-10	1.4552	CF-8C	J92710
<b>Non stabilized</b>					
	X4CrNi18-10		1.4301	302 (TP)304	S30400
	X2CrNi19-11		1.4306	(TP)304L	S30403
		G-X5CrNi19-10	1.4308	CF-8	J92600
			1.4312	(TP)304H	S30409

## PACKAGING AND AVAILABLE SIZES

Diameter (mm)	1.6	2.0	2.4	3.2
5 kg PE-Tube	X	X	X	X

Note : Cut length = 1000 mm

LNT 347Si : rev. C-EN24-01/02/16