

LNT 347Si

CLASSIFICATION

AWS A5.9 - ER347S
ISO 14343-A - W 19.9 NbSi

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)

I1 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

Typical values	Shielding gas	Condition	0.2% proof strength (N/mm ²)	Tensile strength (N/mm ²)	Elongation (%)	Impact ISO-V(J)	
						+20°C	-196°C
	I1	AW	400	650	35	80	45

MATERIALS TO BE WELDED

Steel grades	EN 10088-1/-2	EN 10213-4	Mat. Nr	ASTM/ACI A240/A312/A351	UNS
Ti-Nb stabilized	X6CrNiTi 18-10		1.4541	(TP)321 (TP)321H	S32100 S32109
	X6 CrNiNb 18-10		1.4550	(TP)347 (TP)347h	S34700 S34709
		GX5 CrNiNb 19-10	1.4552	CF-8C	J92710
Non stabilized				302	
	X4 CrNi 18-10		1.4301	(TP)304	S30400
	X2 CrNi 19-11		1.4306	(TP)304L	S30403
		GX5 CrNi 19-10	1.4308	CF-8	J92600
			1.4312	(TP)304H	S30409

PACKAGING AND AVAILABLE SIZES

Diameter (mm)	1.6	2.0	2.4	3.2
Unit : 2 & 10 kg tube	X	X	X	X

Note : Cut length = 1000 mm

Other sizes and packaging on request

LNT 347Si rev. EN 23