



TIG 347Si



Standards

AWS 5.9	EN ISO 14343-A	W. Nr.
ER 347Si	W 19 9 NbSi	1.4551

Description & applications

Filler metal in solid wire sticks for TIG welding of austenitic stainless steels without Molybdenum. Grade 347Si is stabilized with Niobium to prevent intergranular corrosion in weldments; the high Silicon content improves the wettability of the molten metal.

Niobium also increases creep resistance up to 400 °C.

Typical chemical composition (%)

C max	Mn	Si	Cr	Ni	Nb	S max	P max	Fe
0.03	1.5	0.85	19.5	9.5	0,45	0.02	0.02	Base

Typical mechanical properties of all-weld metal

Rm	Rp 0,2	A5	KV -196°C
620 MPa	410 Mpa	35 %	45 J

Operating parameters

Shielding gas recommendations :

EN ISO 14175 II : 100 % Argon 6 – 12 l/mn Root: Argon, Nitrogen 3 – 6 l/mn



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