

M-347

AWS ER347
JIS Y347

FOR STAINLESS STEEL

Typical applications

Welding of stainless alloys of the 18%Cr-9%Ni-Nb(Ti) types (STS 321, 347)
Nb component improves the resistance to intergranular corrosion of the weld metal.

Typical chemical composition of wire (%)

C	Si	Mn	Ni	Cr	Nb+Ta
0.05	0.46	2.24	9.30	19.30	0.60

Typical mechanical properties of all-weld-metal

Shielding Gas	T · S N/mm ² {kgf/mm ² }	El (%)	IV (J)
Ar+2%O ₂	640 {65}	41	—

Package

Dia. (mm)	0.8	0.9	1.0	1.2	1.4	1.6
Spool. (kg)	5, 12.5, 20					
Pailpack.(kg)	200, 250			200, 250, 300		

Approved by