

AIMTEK Grade 347 Welding Wire

Typical Composition:	C: 0.07% max Mn: 1.00 – 2.00% Si: 0.30 – 1.00% P: 0.030% max S: 0.030% max Cr: 17.00 – 20.00% Ni: 9.00 – 13.00% Cb (Nb): 12 x C min Mo: 0.75% max Cu: 0.75% max
Size/diameter (inches):	0.030" to 0.125"
Industry Specifications:	AMS5680, MSRR9500/207, AWS A5.9 ER347, EN ISO 14343 W19 9 Nb, UNS S34781
Forms Available:	Spools, coils, cut lengths
Applications:	GMAW and GTAW process welding rod for joining and surfacing applications with matching and similar stabilized and non-stabilized austenitic stainless steel grades. Resistant to intercrystalline corrosion and wet corrosion up to 400°C. Corrosion-resistance similar to matching grades.
Suggested Operating Parameters:	Suggested heat input is max. 1.5 kJ/mm and interpass temperature max. 100°C. Post-weld heat treatment generally not needed. Always consult the supplier of the parent material or seek other expert advice to ensure that the correct heat treatment process is carried out. Polarity: DC – Shielding Gas: 100% Argon Gas flow: 4 – 8 liters/minute

