



SELECTARC MIG 20/10NB

Old reference : MIG 347

Classification

AWS A5.9 : ER 347

AMS

: 5680

Characteristics

Solid wire electrode for Gas Metal Arc Welding, Niobium / Columbium stabilized 18%Cr-8%Ni type stainless steel wire with increased Carbon, suited to weld Ti or Nb stabilized stainless steels, used for high temperature service. Good protection from intergranular corrosion.

Applications

Welding stainless steels for high temperature services. Aerospace, Petrochemical industries, Energy field.

Base Materials

UNS	Alloy	EN	Material N°
S30409	304 H	X6CrNi18-10	1.4948
S32109	321 H	X8CrNiTi18-10	1.4878
S34709	347 H	X7CrNiNb18-10	1.4912

Typical Weld Metal Composition (%)

C	Si	Mn	Cr	Ni	Mo	Cu	Nb	P	S	Fe
0.050	0.450	1.70	19.50	9.10	0.20	0.10	0.650	0.015	0.010	base

All Weld Metal Mechanical Properties (Typical)

Conditions	UTS R _m (MPa)	YS R _{p0.2} (MPa)	% Elg A ₅	Impact (kV) Temp. °C	J	FN (WRC)
AW	660	490	35	+ 20	140	10

Welding Current & Instructions

Welding Mode	Wire Ø (mm)	Welding Mode		Shielding Gas
		(A)	(V)	
MIG = +	0.8	100 - 150	22 - 27	Ar + 2 % CO ₂ Ar + 1 % O ₂ 18 - 20 l/min
	1.0	120 - 200	24 - 28	
	1.2	140 - 220	24 - 28	
	1.6	180 - 260	24 - 30	

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