



TIG 20/10NB

Old reference: TIG 347

Classification

ISO 14343-A : W 19 9 Nb
AWS A5.9 : ER347

Material.N° : 1.4551

Description & Applications

Solid rod for TIG welding of stabilised stainless steels (347, 321...) or low carbon content stainless steels (304L...). Good intergranular resistant corrosion.

The TIG process is particularly suited for welding of piping systems, works of fine thinness equal or inferior than 3 mm and for penetration passes.

Typical Chemical Composition (%)

C	Si	Mn	Cr	Ni	Mo	Nb	Cu	P	S	Fe
0.045	0.4	1.5	19.4	9.3	0.1	0.6	0.1	<0.02	<0.01	Rem.

All Weld Metal Mechanical Properties

R _{p0.2} (MPa)	R _m (MPa)	A ₅ (%)	KV (J)
490	660	35	+20°C 140

Welding Current & Instructions

Welding mode	Shielding Gas
TIG = -	Ar : 6-12 l/min Back shielding : Argon / Nitrogen : 3-6 l/min

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