



TIG 347H

Classification

AWS A5.9 : ER347 (347H)

ISO 14343-A : W 19 9 Nb

Description & Applications

Rod for Gas Tungsten Arc Welding, Niobium / Columbium stabilized 18%Cr-8%Ni type stainless steel rod with increased Carbon, suited to weld Ti or Nb stabilized stainless steels, used for high temperature service.

Base materials

Stainless steels for high temperature services:

| UNS | Alloy | EN 10088 | Material N° |
|--------|-------|---------------|-------------|
| S30409 | 304H | X6CrNi18-10 | 1.4948 |
| S32109 | 321H | X8CrNiTi18-10 | 1.4878 |
| S34709 | 347H | X7CrNiNb18-10 | 1.4912 |

Typical Chemical Composition (%)

| C | Si | Mn | Cr | Ni | Mo | Cu | Nb | P | S | FN |
|------|------|-----|------|-----|-----|-----|------|-------|-------|-----|
| 0.05 | 0.45 | 1.7 | 19.5 | 9.1 | 0.2 | 0.1 | 0.65 | <0.03 | <0.02 | ~10 |

All Weld Metal Mechanical Properties

| $R_{p0.2}$ (MPa) | R_m (MPa) | A_5 (%) |
|--------------------|---------------|-------------|
| >380 | >580 | >30 |

Welding Current & Instructions

| Welding mode | Shielding Gas |
|--------------|---|
| TIG = - | Ar : 6-12 l/min Back shielding : Argon or Nitrogen /H ₂ : 3-6 l/min |

Ind.11



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