

Classifications

EN ISO 14343-A	AWS A5.9 / SFA-5.9
S 19 9 Nb	ER347

Characteristics and typical fields of application

Solid wire of S 19 9 Nb / ER347 type for joining and surfacing application with matching and similar stabilized and non-stabilized austenitic CrNi(N)-steels and cast steel grades. Resistant to intercrystalline corrosion and wet corrosion up to 400°C. Corrosion resistance similar to matching stabilized austenitic CrNi-steels and cast steel grades.

Recommended SAW flux:

Marathon 213
 Marathon 431

Base materials

1.4301 X5CrNi18-10, 1.4306 X2CrNi19-11, 1.4311 X2CrNi18-9, 1.4312 GX10CrNi18-8, 1.4541 X6CrNiTi18-10, 1.4546 X5CrNiNb18-10, 1.4550 X6CrNiNb18-10, 1.4552 GX5CrNiNb19-11
 UNS S30400, S30403, S30453, S32100, S34700
 AISI 347, 321, 302, 304, 304L, 304LN
 ASTM A296 Gr. CF 8 C, A157 Gr. C9, A320 Gr. B8C or D

Typical analysis

	C	Si	Mn	Cr	Ni	Nb
wt.-%	0.05	0.40	1.7	19.2	9.2	0.65

Operating data

Dimension mm	Current A	Voltage V
2.4	300 – 400	28 – 32
3.0	320 – 450	29 – 33
3.2	350 – 500	29 – 33
4.0		

Suggested heat input is max. 1.5 kJ/mm and interpass temperature max. 100°C. Generally no heat treatment needed. Suggested heat input is max. 2.0 kJ/mm and interpass temperature max. 150°C.

Approvals

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