

ER347H

TIG (GTAW)

SOLID WIRE FOR 321H/347H STAINLESS STEELS

PRODUCT DESCRIPTION

Solid wire for TIG welding of 321H/347H stainless steel

CLASSIFICATIONS

AWS A5.9M	ER347
ISO 14343-A	19 9 Nb
ISO 14343-B	SS347

ASME IX QUALIFICATION

QW432	F-No 6
QW442	A-No 8

CHEMICAL COMPOSITION [WIRE WT %]

	C	Mn	Si	S	P	Cr	Ni	Mo	Nb	Cu	FN
Min.	0.04	1.0	0.30	--	--	19.0	9.0	--	10xC	--	3
Max.	0.08	2.5	0.65	0.020	0.030	20.0	11.0	0.3	1.0	0.3	9
Typical	0.055	1.7	0.4	0.005	0.02	19.5	9.2	0.1	0.6	0.1	8

ALL-WELD MECHANICAL PROPERTIES

As welded	Typical	High Temperature		
		650°C	732°C	815°C
Tensile strength (MPa)	660	398	312	235
0.2% proof strength (MPa)	450	318	244	184
Elongation (%) 4d	42	23	22	22
5d	40	21	20	21
Reduction of area (%)	67	55	53	52
Impact ISO-V(I) +20°C	125	--	--	--
Hardness cap/mid (HV)	190/230	--	--	--

TYPICAL OPERATING PARAMETERS

Shielding gas	Current	Diameter (mm)	Parameters
	DC-	2.4	100A, 12V

* Also required as a purge for root runs.

PACKAGING DATA

Diameter (mm)	Weight (kg)	Packaging	Item number
2.4	2.5	PE TUBE	TER347H-24

HIGH TEMPERATURE ALLOYS