LNM 347Si

TOP FEATURES

- The weld metal has a high resistance to corrosive media at service temperatures <400°C.
- The presence of niobium reduces the propensity of intergranular chromium carbide precipitation and thus reduces the susceptibility to intergranular corrosion.
- The increased silicon content results in increased weld pool fluidity to give a smooth deposit appearance.

CLASSIFICATION

AWS A5.9	ER347Si
EN ISO 14343-A	G 19 9 NbSi

SHIELDING GASES (ACC. EN ISO 14175)

M12	Mixed gas Ar+ 0.5-5% CO2
M13	Mixed gas Ar+ 0.5-3% O2

TYPICAL APPLICATIONS

- Process Industries
- Pharmaceutical Equipment
- High Temperature Stainless Applications

APPROVALS

TÜV	DB	CE
+	+	+

CHEMICAL COMPOSITION (WEIGHT %), TYPICAL WIRE

C	Mn	Si	Cr	Ni	Mo	Nb
0.05	1.4	0.7	19.2	9.9	0.1	0.6

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Shielding gas	Condition*	0.2% Proof strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J)	
						+20°C	-196°C
Typical values	M12	AW	460	650	35	100	40

* AW = As welded

PACKAGING AND AVAILABLE SIZES

Wire diameter (mm)	Packaging	Weight (kg)	Item number
1.0	SPOOL (BS300)	15.0	581249
	DRUM	250.0	581257
1.2	SPOOL (BS300)	15.0	581256
	DRUM	250.0	581258

TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application

Safety Data Sheets (SDS) are available here:

Subject to Change – The information is accurate to the best of our knowledge at the time of printing.
Please refer to www.lincolnelectric.eu for any updated information.