

347S96

SAW

SOLID WIRE FOR SAW OF 321/347

PRODUCT DESCRIPTION

Solid wire for sub-arc welding.

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.	--	1.0	0.30	--	--	19.0	9.0	--	10xC	--	4
Max.	0.08	2.5	0.65	0.020	0.030	21.0	11.0	0.3	1.0	0.3	12
Typical	< 0.04	1.5	0.4	0.005	0.02	19.5	9.7	0.2	0.6	0.1	8

ALL-WELD MECHANICAL PROPERTIES

TAs welded	Typical
Tensile strength (MPa)	660
0.2% proof strength (MPa)	450
Elongation (%) 4d	42
5d	40
Impact ISO-V(J) 20°C	230
- 50°C	150
- 196°C	35
Hardness cap/mid (HV)	220/240

TYPICAL OPERATING PARAMETERS

Flux	Current	Diameter (mm)	Parameters
P2007 or SSB	DC+	2.4	350A, 28V

PACKAGING DATA

Diameter (mm)	Weight (kg)	Packaging	Item number
2.4	25	B415	SA347S96-24