

ER347H

TOP FEATURES

- Ferrite number between 3-9
- High carbon & Niobium stabilised

CLASSIFICATION

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

SHIELDING GASES (ACC. EN ISO 14175)

I1	Inert gas Ar (100%)
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CHEMICAL COMPOSITION (WEIGHT %), WIRE

	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

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

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	21
Reduction of area (%)	67	55	53	52
Impact ISO-V (J) +20°C	125			
Hardness, cap/mid (HV)	190/230			

PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Weight (kg)	Item number
2.4	PE Tube	2.5	TER347H-24

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.