Techalloy® 347

AWS ER347

CONFORMANCES

AWS A5.9 ER347

UNS S34780

ISO 14343: 2009 (19 9 Nb)

Techalloy® 347 electrodes are niobium stabilized stainless steel electrodes used for the welding of types 347 and 321 stainless and stainless clad steels. The addition of niobium reduces intergranular corrosion in severe operating conditions.

Applications: Food processing, Pharmaceutical equipment

DIAMETERS / PACKAGING

Diameter in	(mm)	MIG WIRE 33 lb (14.9 kg) Wire Basket	TIG 10 lb (4.5 kg) Tube 30 lb (13.6 kg) Master Carton	SAW WIRE 55 lb (25 kg) Coil
0.035	(0.9)	MG347035667		
0.045	(1.2)	MG347045667		
*1/16	(1.6)	MG347062667	TG347062638	
*3/32	(2.4)		TG347093638	SA347093726
1/8	(3.2)		TG347125638	SA347125726

*Bulk packages available - Contact Lincoln Electric

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THE WELDING EXPERTS®

DEPOSIT COMPOSITION

	%C	%Cr	%Ni	%Mo	%Nb + Ta
Requirements AWS ER347	0.08 max.	19.0 - 21.5	9.0 - 11.0	0.75 max.	10 x C - 1.0
Typical Performance Techalloy® 347	0.03	19.5	9.3	0.25	0.60
	%Mn	**%Si**	**%P**	**%S**	**%Cu**
Requirements AWS ER347	1.0 - 2.5	0.30 - 0.65	0.03 max.	0.03 max.	0.75 max.
Typical Performance Techalloy® 347	1.7	0.45	0.01	0.007	0.10

TYPICAL OPERATING PROCEDURES

Process	Diameter in (mm)	Voltage (volts)	Amperage	Gas Flow	Gas
MIG	0.035 (0.9) 0.045 (1.2) 1/16 (1.6)	26-29 28-32 29-33	160-210 180-250 200-280	30-50 CFH	98/99% Argon + 2/1% Oxygen 97% Argon + 3% CO_2
TIG	1/16 (1.6) 3/32 (2.4) 1/8 (3.2)		90-130 120-175 150-220	20-40 CFH	100% Argon
SAW	3/32 (2.4) 1/8 (3.2)	28-33 29-32	275-350 350-450		Lincolnweld® P2007

Material Safety Data Sheets (MSDS) are available on our website at www.techalloy.com

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