

INERTROD 347

TOP FEATURES

- The weld metal has a high resistance to corrosive media at service temperatures <math><400^{\circ}\text{C}</math>.
- The presence of niobium reduces the possibility of intergranular chromium carbide precipitation and thus reduces the susceptibility to intergranular corrosion.

TYPICAL APPLICATIONS

- Fabrication of pipes, plates, vessels

CLASSIFICATION

AWS A5.9. ER347
EN ISO 14343-A W 19 9Nb

SHIELDING GASES (ACC. EN ISO 14175)

I1 Inert gas Ar (100%)

APPROVALS

| TÜV | DB | CE |
|-----|----|----|
| + | + | + |

CHEMICAL COMPOSITION (WEIGHT %), TYPICAL, WIRE

| C | Mn | Si | P | S | Cr | Ni | Nb |
|------|-----|------|--------|--------|------|----|-----|
| 0.04 | 1.6 | 0.45 | ≤0.025 | ≤0.020 | 19.5 | 10 | 0.5 |

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

| | Shielding gas | Condition* | Yield strength (MPa) | Tensile strength (MPa) | Elongation (%) | Impact ISO-V (J) | |
|----------------|---------------|------------|----------------------|------------------------|----------------|------------------|--------|
| | | | | | | +20°C | -120°C |
| Typical values | I1 | AW | ≥400 | ≥550 | ≥30 | ≥65 | ≥32 |

* AW = As welded

PACKAGING AND AVAILABLE SIZES

| Diameter x Length (mm) | Packaging | Weight (kg) | Item number |
|------------------------|-----------|-------------|-------------|
| 1.0 | PE Tube | 5.0 | W000283433 |
| 1.6 | PE Tube | 5.0 | W000283435 |
| 2.0 | PE Tube | 5.0 | W000283436 |
| 2.4 | PE Tube | 5.0 | W000283437 |

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.