OK Tigrod 347

Bare, corrosion-resistant, chromium-nickel rods for welding stabilised austenitic chromium-nickel alloys of the 18% Cr-8% Ni type. The rods are stabilised with niobium, which provides good resistance to the intergranular corrosion of the weld metal. Due to the niobium content, this alloy is recommended for use at higher temperatures.

Specifications	
Classifications	EN ISO 14343-A : W 19 9 Nb SFA/AWS A5.9 : ER347 Werkstoffnummer : ~1.4550
Approvals	CE : EN 13479 UKCA : EN 13479 VdTÜV : 19918

Approvals are based on factory location. Please contact ESAB for more information.

Alloy Type	Austenitic (with approx. 8 % ferrite) 19% Cr - 9% Ni - Nb
Shielding Gas	I1 (EN ISO 14175)

Typical Tensile Properties			
Condition	**Yield Strength**	**Tensile Strength**	**Elongation**
As Welded	510 MPa (74 ksi)	655 MPa (95 ksi)	35 %

Typical Charpy V-Notch Properties		
Condition	**Testing Temperature**	**Impact Value**
As Welded	20 °C (68 °F)	130 J (96 ft-lb)

Typical Weld Metal Analysis %									
C	**Mn**	**Si**	**S**	**P**	**Ni**	**Cr**	**Mo**	**V**	**Al**
0.04	1.3	0.4	0.009	0.016	9.2	18.8	0.1	0.05	0.002

Typical Weld Metal Analysis %					
Cu	**N**	**Nb**	**Ti**	**Co**	**FN WRC-92**
0.1	0.06	0.6	0.003	0.1	8

Typical Wire Composition %									
C	**Mn**	**Si**	**S**	**P**	**Ni**	**Cr**	**Mo**	**Cu**	**N**
0.04	1.4	0.39	0.013	0.014	9.4	19.3	0.1	0.1	0.05

Typical Wire Composition %	
Nb	**FN WRC-92**
0.7	8