

MI 347

Gas Metal Arc (MIG/MAG) Welding Wire - Stainless Steels

Standards

AWS/ASME SFA - 5.9	ER347
EN ISO 14343 - A	G 19 9 Nb
TS EN ISO 14343 - A	G 19 9 Nb
DIN M. No.	1.4316

Properties and Applications

Stabilized austenitic stainless steel wire electrode for GMA (MIG/MAG) welding of unstabilized and stabilized corrosion resistant Cr-Ni steels, used in food, beverage, chemical and pharmaceutical industries. Stabilized with Nb (Niobium) and resistant to intergranular corrosion. Weld metal is suitable for operating temperatures of up to 400°C, non-scaling up to 800°C, in air and oxidizing combustion gases.

Materials

EN	Material	ASTM
X5CrNi18-10	1.4301	304
X4CrNi18-12	1.4303	305
X2CrNi19-11	1.4306	304L
GX5CrNi19-10	1.4308	CF-8
X10CrNi18-8	1.4310	301 - 302
X5CrNi17-7	1.4319	
X6CrNiTi18-10	1.4541	321
X6CrNiNb18-10	1.4550	347, 347H
GX5CrNiNb19-11	1.4552	

Typical Chemical Features of the Welding Wire

Type of Analysis	C	Si	Mn	Cr	Ni	Nb
Welding Wire	0.04	0.40	1.40	19.50	9.50	0.70

Typical Mechanical Values of Weld Metal

Test Condition	Protection Gas	Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Elongation A5 (%)	Charpy V-Notch Properties (J)
As welded	M13	430	620	32	20°C → 80

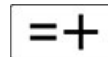
* Chemical composition and mechanical properties are valid when using shielding gas EN ISO 14175 - M13 (Ar+%0,5-3 O2).

Application Information

Welding Positions



Polarity:



Protection Gas:
M13 M12 M14 I1

Welding Parameters & Efficiency

Packaging Information

Product Code	Diameter (mm)	Pieces per Box (~)	Weight Of The Box (kg)	Boxes Per Package	Weight Of The Package	Packaging Type
23008BAKM2	0.80	1 kg	1.0	14	15.7	Plastic Spool (D100)
23008BJAM2	0.80	15 kg	15.0	1	15.7	Wire Basket Spool (K300MS)
23008DJAM2	1.00	15 kg	15.0	1	15.7	Wire Basket Spool (K300MS)
23008EJAM2	1.20	15 kg	15.0	1	15.7	Wire Basket Spool (K300MS)

Storage & Re-Drying Information

Shouldn't be exposed to high statical load and impact.