

Filler rod and wire

Features: • Suitable for 18%Cr-8%Ni-Nb and 18%Cr-8%Ni-Ti steel

Classification: AWS A5.9 ER347

Shielding gas: Ar

Identification color: 1st Blue

Polarity: DCEN

Packaging data

φ mm	Spool		Tube	
	kg	kg	Length mm	g/piece
1.0	10	-	-	-
1.2	10	5	1,000	9
1.6	10	5	1,000	16
2.0	-	5	1,000	25
2.4	-	5	1,000	36
3.2	-	5	1,000	64
Volume mm	240W, 110H, 240L		40W, 35H, 1015L	

Composition (rod and wire mass%)

	Typical	Guaranty ^a
C	0.05	0.08
Si	0.40	0.30~0.65
Mn	2.1	1.0~2.5
P	0.02	0.03
S	0.01	0.03
Ni	10.0	9.0~11.0
Cr	19.3	19.0~21.5
Mo	0.07	0.75
Cu	0.07	0.75
Nb	0.6	10xC~1.0

Note: ^a Single values are maximum.

Welding parameters (A)

φ mm	
1.0	50~80
1.2	50~100
1.6	100~200
2.0	100~200
2.4	150~250
3.2	200~300

All-weld mechanical properties

	Typical
0.2%YS (MPa)	460
TS (MPa)	630
El on 4d (%)	38
IV 0°C (J)	88

Approvals

NK	KY347