

MIGINOX 347 / TIGINOX 347

Classification

AWS A/SFA 5.9 : ER 347

Characteristic

This filler is used for TIG/MIG welding of austenitic alloys of 18Cr-8Ni type. The alloy is stabilized with niobium to improve resistance to inter-granular corrosion of the weld metal. The alloy is recommended for use at higher temperatures.

Typical Application

For welding stainless steel type AISI 321 & 347. Used in the manufacture of equipment for chemicals, food and aircraft industries. for welding of gas turbines and equipments in soap industries.

Wire Chemistry

| C | S | P | Mn | Si | Cr | Ni | Mo | Cu | Nb |
|----------|----------|----------|---------|-----------|-----------|----------|----------|----------|---------|
| 0.08 max | 0.03 max | 0.03 max | 1.0-2.5 | 0.30-0.65 | 19.0-21.5 | 9.0-11.0 | 0.75 max | 0.75 max | 1xC-1.0 |

Properties of weld metal with 100% Argon gas shielding Current Condition: DC (+) in GMAW

Classifications:

All Weld Mechanical Properties As welded condition

| | | |
|----------------------|-----|------------------|
| Yield strength MPa | 470 | CVN Impact value |
| UTS MPa | 640 | 70J at 20°C |
| Elongation % (L=4xd) | 37 | 45J at (-60)°C |

The chemistry and mechanical properties of the weld metal will vary with the type of shielding gas used.

Packing Specifications

Supplied in D 300 plastic spools - layer wound / Weight - 12.5 Kg

Each plastic spool is sealed in a polyethylene bag and then packed in a corrugated box which is shrink-wrapped.

Packing Specifications for MIGINOX 347

| | | | | | |
|---------------------|------|------|------|------|------|
| Dia., mm | 1.0 | 1.2 | 1.6 | 2.0 | 2.2 |
| Net wt per spool,kg | 12.5 | 12.5 | 12.5 | 12.5 | 12.5 |

Packing Data for TIGINOX 347

| | | | | | |
|-----------------------------|------|------|------|------|------|
| Dia., mm | 1.0 | 1.2 | 1.6 | 2.0 | 2.5 |
| Length,mm | 1000 | 1000 | 1000 | 1000 | 1000 |
| Net wt per tube,kg | 5 | 5 | 5 | 5 | 5 |
| No of Plastic Tubes per Box | 4 | 4 | 4 | 4 | 4 |
| Net wt,Box,kg | 20 | 20 | 20 | 20 | 20 |



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