

## TECHNICAL DATASHEET - WELDING CONSUMABLE

<b>AWS Code:</b>	ER347
<b>Product Code:</b>	RW 347
<b>Werkstoff No.:</b>	1.4551
<b>MIG Certification:</b>	CE
<b>TIG Certification:</b>	CE

### EQUIVALENT OF OTHER STANDARD

EN ISO 14343-A:2017 Nominal Composition	AWS A5.9:2017 Alloy Designation	EN ISO 14343-B:2017 Alloy Type	AWS A5.9:2017 Composition Designation
19 9 Nb	ER347	SS347	ER347

### DESCRIPTION AND APPLICATIONS

RW 347 / RW 347SI is used for AISI 347, AISI 321 and similar Cr-Ni stainless steels alloyed with Nb, Ti or Ta for carbide control. Nb reduces chromium carbide precipitation risk at grain boundaries and supports intergranular corrosion resistance. Lower Si content helps reduce hot-cracking sensitivity. RW 347SI is the Si-alloyed option for Nb/Ti/Ta-bearing stainless steels operating up to 400°C.

### TYPICAL CHEMICAL COMPOSITION (%)

	Min.	Max.
<b>C</b>	-	0,08
<b>Mn</b>	1,00	2,50
<b>Si</b>	0,30	0,65
<b>S</b>	-	0,020
<b>P</b>	-	0,030
<b>Cr</b>	19,0	21,0
<b>Ni</b>	9,0	11,0
<b>Mo</b>	-	0,30
<b>Cu</b>	-	0,30
<b>N</b>	-	-
<b>Nb</b>	10xC	1,00
<b>Ti</b>	-	-

### DIAMETER

<b>MIG sizes</b>	0,8   0,9   1,0   1,14   1,2   1,6
<b>TIG sizes</b>	0,8   0,9   1,0   1,2   1,6   2,0   2,4   3,2   4,0
<b>SAW sizes</b>	1,6   2,0   2,4   3,2   4,0

### PACKAGING

<b>MIG</b>	Blue Metallic Wire Basket BS300: 15 Kg. Plastic Spool D300: 15 Kg. Plastic Spool D200: 5 Kg. Wooden/Metallic Bulk Spool: 250 Kg. Drum: 250-400 Kg.
<b>TIG</b>	Carton Boxes/Tubes: 5 Kg. (1000 mm Rod Length)
<b>SAW</b>	Metallic Wire Basket K415 Wooden/Metallic Bulk Spool: 250 Kg. Drum: 300 Kg.

Note: Safety Data Sheet is available on request.

## TECHNICAL DATASHEET - WELDING CONSUMABLE

<b>AWS Code:</b>	ER347Si
<b>Product Code:</b>	RW 347SI
<b>Werkstoff No.:</b>	1.4551
<b>MIG Certification:</b>	CE
<b>TIG Certification:</b>	CE

### EQUIVALENT OF OTHER STANDARD

EN ISO 14343-A:2017 Nominal Composition	AWS A5.9:2017 Alloy Designation	EN ISO 14343-B:2017 Alloy Type	AWS A5.9:2017 Composition Designation
19 9 Nb Si	ER347Si	SS347Si	ER347Si

### DESCRIPTION AND APPLICATIONS

RW 347 / RW 347SI is used for AISI 347, AISI 321 and similar Cr-Ni stainless steels alloyed with Nb, Ti or Ta for carbide control. Nb reduces chromium carbide precipitation risk at grain boundaries and supports intergranular corrosion resistance. Lower Si content helps reduce hot-cracking sensitivity. RW 347SI is the Si-alloyed option for Nb/Ti/Ta-bearing stainless steels operating up to 400°C.

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<b>Ni</b>	9,0	11,0
<b>Mo</b>	-	0,30
<b>Cu</b>	-	0,30
<b>N</b>	-	-
<b>Nb</b>	10xC	1,00
<b>Ti</b>	-	-

### DIAMETER

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