

## DATASHEET RW 347 – TIG rods

### Description and Applications

Austenitic stainless steel welding wire stabilized with Nb, suitable for welding Cr-Ni stainless parent metals of similar composition stabilized with either Nb, Ti or Ta (type AISI 347, AISI 321). The addition of Nb reduces the possibility of intergranular Cr carbide precipitation and therefore increases the resistance to intergranular corrosion. The low Si content reduces the hot crack sensitivity.

### Rodacciai denomination and approximate equivalent with other standards

#### RW 347

EN ISO 14343-A:2009 W 19 9 Nb  
 EN ISO 14343-B:2009 SS 347  
 AWS A5.9-2012 ER 347

### Filler metal properties

Chemical composition (nominal) in %

	C	Mn	Si	S	P	Cr	Ni	Mo	Cu	Co	Al	Ti	N	Ca	Nb	B	Ce
min	0,020	1,20	0,30			19,00	9,00								12xC		
max	0,060	1,80	0,60	0,015	0,025	20,00	10,00	0,30	0,30	0,30			0,060		0,850	0,003	

### Welding parameters

The welding parameters for TIG welding depend on the wire diameter and the welding application.

Electrode negative and a shielded gas of argon or helium has to be used to avoid burn-up of the tungsten electrode.

Welding positions : down hand, horizontal/vertical, vertical upward, overhead.

Wall thickness : max. 20 mm

Highest operating temperature, in the short term range, as for base metal, but not higher than 350 °C

Lowest operating temperature, as for base metal, but not lower than – 196°C

Resistance to intergranular corrosion proven in accordance with EN ISO 3651-2

### Sizes and marking

Standard sizes : diam. 1,00 – 1,20 – 1,60 – 2,00 – 2,40 – 3,20 and 4,00 mm

Tolerances on diameter : + 0,01 / - 0,04 mm

Marking : Each rod is stamped one end with ER 347 and RW 1.4551

### Packaging forms

White carton boxes of 5 kg.

Red, white or blue coloured cardboard tubes of 5 kg.

Wooden crates of 250 kg.