



Changzhou Sanzhong Welding Materials Co.,Ltd

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Standard: AWS A 5.9 YB/T5092	Chemical Composition %											
	C	Mn	Si	Cr	Ni	P	S	Mo	Nb			
Grade ER347	≤0.08	1.0–2.5	0.3 – 0.65	19 – 21.5	9 – 11	≤0.03	≤0.03	≤0.75	10×C–1.0			
Type	Spool (MIG)					Tube (TIG)						
Specification (MM)	0.8、0.9、1.0、1.2、1.6、2.0					1.6、2.0、2.4、3.2、4.0、5.0						
Package	S100/1kg S200/5kg S270,S300/15kg-20kg				5kg/box	10kg/box	length :1000MM					
Diameter (MM)	0.8	1.0	1.2	1.6	2.0	2.5	3.2					
Current (A)	70 ~ 150	100 ~ 200	140 ~ 220	50 ~ 100	100 ~ 200	200 ~ 300	300 ~ 400					
Application	<p>ER347 is also known as H08Cr20Ni10Nb. The main composition is 19Cr-11Ni-Nb, which can be welded in full position. NB is added on the basis of SUS308. It can effectively improve the corrosion resistance, especially the resistance to grain boundary corrosion, the resistance to intergranular corrosion of welding pass can be enhanced, and has excellent high temperature strength. Especially suitable for heat resistant steel welding. Excellent welding performance-smooth wire feeding, stable arc, beautiful shape, few spatter.</p> <p>Often used in food machinery, such as 07Cr19Ni11Ti (SUS321). 07Cr18Ni11Nb (SUS347) .</p>											
Notice	<ol style="list-style-type: none"> 1. Oil, dirt and rust on the welding wire surface should be removed before welding. Surface impurities such as oil, rust and water should be thoroughly removed in the welding place, so as to prevent blowhole, crack and so on during welding. The surface of the groove and its surroundings should be polished with metallic gloss. 2. In order to obtain good mechanical properties of welding seam, suggest protect gas Ar+2%O2 and shield gas flow rate 20-25 L/min for MIG welding. For TIG welding,suggest protect gas pure Ar and shield gas flow rate 8-15 L/min ,Arc length 1~3 mm; Length of the tungsten pole is about 3~5 mm; wind speed limit ≤ 1.0 m/s, argon protection at the back of welding area . 3. In the welding process, the welding line energy directly affects the mechanical properties and crack resistance of weld metal, and should be paid more attention to. 4. The above welding methods, conditions and specifications are for reference only. Users should evaluate the welding process according to their own welding characteristics before using the welding wire for the formal product welding. 											



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