

SI 347

Submerged Arc Welding Wire - Stainless Steels

Standards

AWS/ASME SFA - 5.9	ER347
EN ISO 14343 - A	S 19 9 Nb
TS EN ISO 14343 - A	S 19 9 Nb
DIN M. No.	1.4551

Properties and Applications

Stabilized austenitic stainless steel welding wire for submerged arc welding of unstabilized and stabilized corrosion resisting Cr-Ni steels. Used in combination with SIF 501 and SIF 502 submerged arc welding fluxes. Generally used for welding pipes, tanks and equipments in food, beverage, chemical and pharmaceutical industries. Stabilized with Cb (Nb) and resistant to intergranular corrosion. Weld metal is suitable for operating temperatures of up to 400°C, non-scaling up to 800°C, in air and oxidizing combustion gases.

Typical Chemical Features of the Welding Wire

Type of Analysis	C	Si	Mn	Cr	Ni	Nb
Welding Wire	0.04	0.40	1.40	19.50	9.50	0.60



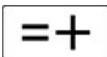
Typical Chemical Values of Weld Metal

Welding Flux	Type of Analysis	C	Si	Mn	Cr	Ni	Nb
SIF 502	Weld Deposit	0.04	0.65	0.95	19.50	9.00	0.35
SIF 501	Weld Deposit	0.04	0.35	1.50	19.00	8.50	0.30

Typical Mechanical Values of Weld Metal

Test Condition	Welding Flux	Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Elongation A5 (%)	Charpy V-Notch Properties (J)		
As welded	SIF 502	430	610	26	20°C → 70	-60°C → 55	-196°C → 35
As welded	SIF 501	460	610	32	20°C → 90	-60°C → 75	-196°C → 45

Application Information

<p>Welding Positions</p> <div style="display: flex; justify-content: space-around;"> <div style="text-align: center;">  <p>PA</p> </div> <div style="text-align: center;">  <p>PB</p> </div> </div>	<p>Polarity:</p> <div style="text-align: center;">  </div>		
<p>Welding Parameters & Efficiency</p> <table border="1" style="width: 100%;"> <tr> <td style="text-align: center;">Diameter (mm)</td> </tr> <tr> <td style="text-align: center;">3.20</td> </tr> </table>		Diameter (mm)	3.20
Diameter (mm)			
3.20			

Packaging Information

Product Code	Diameter (mm)	Quantity per Box	Box Gross Weight (kg)	Boxes per Outer Box	Outer Box Gross Weight (kg)	Packaging Type
43004LXAM2	3.20	25 kg	25.20	1	25.20	Wire Basket Spool (K435)