

Specifications:

AWS A5.9
AWS Class ER347
ASME SFA 5.9
UNS S34780

Properties:

Tensile Strength: 91,000-96,000 psi
Yield Strength: 65,000 psi
Elongation: 41-42%

Description:

ER347 is a filler metal that allows for a reduced likelihood of intergranular carbide precipitation with the use of stabilizers, niobium and tantalum. ER347 was created for welding where maximum resistance is needed and the metal will be subjected to higher temperatures. This alloy is used to weld base metals of similar chromium-nickel stainless steel composition. This alloy is most often used in chemical and food processing industries where higher temperatures are required.

Available in multiple sizes and diameters in spool and wire rods.

Chemical Composition (Wt%):

Si	Mn	Cu	Mo	S	Ni	Cr	P	C	Nb + Ta
0.30-0.65	1.0-2.5	0.75	0.75	0.03	9.0-11.0	19.0-21.5	0.03	0.08	(10 x C) min – 1.0 max

Note: Single values are maximum unless otherwise noted.

Maintaining a proper welding procedure, including pre-heat and interpass temperatures, may be critical depending on the type and thickness of material being welded.

CAUTION: Consumers should be thoroughly familiar with the safety precautions on the warning label posted in each shipment and in the American National Standards A49.1, "Safety in Welding and Cutting," published by the American Welding Society, 8669 NW 36 Street, #130, Miami, FL 33126: OSHA Safety and Health Standards 29 CFR 1910 is available from the U.S. Department of Labor, Washington, D.C. 20210.