

RAAJMIG ER 347

Stainless steel continuous & cut length solid welding wire for MIG/TIG welding

CLASSIFICATION : AWS/SFA-5.9: ER347, BS 19.9Nb
DIN 8556: WK. 1.4551

CHARACTERISTICS : ER347 are Niobium stabilized 18Cr-8Ni type welding wires are designed to produce excellent weld appeal with Argon+O₂ or CO₂ mixtures as shielding gas.

APPLICATION : ER 347 is Niobium stabilized grades are suitable for MIG/TIG/ SA welding of type AISI 321 and the 18/8 types which are likely to be subject to temperatures of above 400°C but not more than 850°C. The higher Silicon grades give better weld flow & smoother weld beads.

SHIELDING GAS : welding with 100% Ar gas Or Ar+2%O₂ gas.

CHEMICAL COMPOSITION % (solid wire chemistry)

C	Mn	Si	S	P	Ni
0.080 max.	1.00-2.50	0.30-0.65	0.030 Max	0.030 Max	9.00-11.00
Cr	Mo	Cu	Nb		
19.0-21.50	0.75 max.	0.75 Max	0.45-1.0		

ALL WELD MECHANICAL PROPERTIES (UNDER Ar GAS SHIELD)

UTS (N/mm ²)	Proof strength (N/mm ²)	EL %	CHARPY "V" NOTCH IMPACT AT	FERRITE Qty.(FN)
560-680	420-520	30-40	+ 20 ⁰ C : 50-80 J	5-8

DIEMENSION, CURRENT CONDITION & PACKING DATA (RAAJMIGER347)

Size(mm)	Size(inch)	Current Condition (DC+)	Voltage (V)	Gas Flow Rate L/min.	Spool packing 12.5 kg.	Spool packing 15 kg	Drum packing 100/200kg
0.80	0.031	70-220	16-24	10-20	√	√	X
1.20	0.047	150-300	24-34	15-25	√	√	√
1.60	1/16"	150-350	28-36	15-30	√	√	√

DIEMENSION, CURRENT CONDITION & PACKING DATA (RAAJTIGER347)

Size(mm)	Size(inch)	Length (mm)	Length (inch)	Current Condition (DC+)	Voltage (V)	Tube packing 5 kg	Box packing 20 kg
1.60	1/ 16"	1000	36"	40-80	10-16	√	√
2.0	5/ 64"	1000	36"	50-100	12-18	√	√
2.4/ 2.5	3/ 32"	1000	36"	60-120	14-20	√	√
3.2	1/ 8"	1000	36"	100-150	16-24	√	√
4.0	5/ 32"	1000	36"	140-200	18-28	√	√

Raajratna offer a wide range of Stainless steel welding wires for MIG/TIG/SA welding. And also available RAAJMIGER347Si version for MIG welding process

Customer packing on request.