



# Cromamig 347Si

GMAW - MIG MAG

Stainless Steel

Date: 2008-01-22  
Revision: 14

## Description:

Cromamig 347Si is primarily intended for welding the Nb or Ti stabilised 18% Cr/10% Ni austenitic stainless steel grades 347 and 321. It is also suitable for the unstabilised grades 304 and 304L. For structural applications at temperatures above 400°C, Cromamig 308H is recommended because of its superior strength at elevated temperatures. The higher silicon content gives better arc stability and weld metal flow which improves bead appearance, particularly when dip transfer welding.

## Welding current:

DC+

## Wire composition, wt.%

	C	Si	Mn	P	S	Cr	Ni
Min		0,65	1,0			19,0	9,0
Typical	0,04	0,8	1,3	0,015	0,010	19,5	9,7
Max	0,08	1,00	2,5	0,030	0,020	21,0	11,0

	Mo	Cu	N	Nb <sup>2</sup>
Min				10xC
Typical	0,10	0,10	0,06	0,6
Max	0,30	0,30		1,0

## Shielding gas:

Acc. to EN 439:

M12, Ar + 2% CO<sub>2</sub>, 16-21 l/min

M13, Ar + 1.3% O<sub>2</sub>, 16-21 l/min

## Ferrite content:

FN 8

## Corrosion resistance

Good resistance to general and intergranular corrosion particularly at elevated temperatures.

## Chemical composition, wt.%

	C	Si	Mn	P	S	Cr	Ni
Min							
Typical	0,04	0,8	1,3	0,015	0,01	19,0	9,5
Max							

	Mo	Nb <sup>2</sup>
Min		
Typical	0,1	0,5
Max		

<sup>2</sup> Nb + Ta

## Mechanical properties

	<u>Specified</u>	<u>Typical</u>
Yield strength, Rp0.2%:	≥350 MPa	400 MPa
Tensile Strength, Rm:	≥520 MPa	620 MPa
Elongation, A5	≥30%	30%
Impact energy, CV:		20°C • 110 J -196°C • 30 J

## Classification:

EN ISO 14343

AWS A5.9

G 19 9 Nb Si

ER347Si

## Approvals:

## Product data

Diam.mm	Product code	Dip Current A	Dip Voltage V	Spray Current A	Spray Voltage V
0,8	9822-2008	60-100	18-21	150-170	24-26
1,0	9822-2010	75-140	18-21	170-200	26-28
1,2	9822-2012	130-160	18-21	175-250	26-28