

## DATASHEET RW 347 – MIG wire

### Description and Applications

Austenitic stainless steel welding wire stabilized with Nb, suitable for welding Cr-Ni stainless parent metals of similar composition stabilized with either Nb, Ti or Ta (type AISI 347, AISI 321). The addition of Nb reduces the possibility of intergranular Cr carbide precipitation and therefore increases the resistance to intergranular corrosion. The low Si content reduces the hot crack sensitivity.

### Rodacciai denomination and approximate equivalent with other standards

#### RW 347

EN ISO 14343-A:2009 G 19 9 Nb  
 EN ISO 14343-B:2009 SS 347  
 AWS A5.9-2012 ER 347

### Filler metal properties

Chemical composition (nominal) in %

	C	Mn	Si	S	P	Cr	Ni	Mo	Cu	Co	Al	Ti	N	Ca	Nb	B	Ce
min	0,020	1,20	0,30			19,00	9,00								12xC		
max	0,060	1,80	0,60	0,015	0,025	20,00	10,00	0,30	0,30	0,30			0,060		0,850	0,003	

### Metal properties

The following data are typical for non-heat treated weld metal from MIG welding with M1 DIN EN ISO 14175 as shielded gas.

### Expected minimum mechanical properties of all weld metal

Temperature	°C	20
Yield strength, Rp 0,2	N/mm <sup>2</sup>	350
Tensile strength, Rm	N/mm <sup>2</sup>	550
Elongation, A5	%	25
Impact energy, ISO – V	J	50

### Packaging forms

Blue metallic wire baskets BS300 of 15 kg.

Plastic spools D300 of 12,5 kg for diam. 0,80 mm and of 15 kg for the other diameters.

Plastic spools D200 of 5 kg.

Drum packaging of about 150 kg for diameter 0,80 mm and of about 250 kg for the other diameters.

Diameters : 0,80 – 0,90 – 1,00 – 1,20 – 1,60 mm.