

DATASHEET RW 347 – SAW 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	S 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	

Expected minimum mechanical properties of all weld metal in combination with flux

Temperature	°C	20
Yield strength, Rp 0,2	N/mm ²	450
Tensile strength, Rm	N/mm ²	600
Elongation, A5	%	30
Impact energy, ISO – V	J	70

Packaging forms

Wire basket K415 of 25 kg.

Drum packaging of about 300 kg for diameter 2,00 – 4,00 mm.

Diameters : 1,60 – 2,00 – 2,40 – 3,20 – 4,00 mm