

DATASHEET RW 347 SI – TIG rods

Description and Applications

Filler metal for welding stabilized stainless austenitic steels that are exposed to working temperatures up to 400°C

Rodacciai denomination and approximate equivalent with other standards

RW 347 SI

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

Filler metal properties

Chemical composition (nominal) in %

	C	Mn	Si	S	P	Cr	Ni	Mo	Cu	Co	N	Nb	B
min		1,00	0,65	0,005		19,00	9,00					12xC	
max	0,050	1,50	1,00	0,015	0,020	20,00	10,00	0,30	0,30	0,20	0,060	0,700	0,003

Metal properties

The following data are typical for non-heat treated weld metal from TIG welding with I1 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 ²	390
Tensile strength, Rm	N/mm ²	590
Elongation, A5	%	30
Impact energy, ISO – V	J	80

Sizes and marking

Standard sizes : diam. 1,00 – 1,20 – 1,60 – 2,00 – 2,40 – 3,20 and 4,00 mm

Tolerances on diameter : + 0,01 / - 0,04 mm

Marking : Each rod is stamped one end with ER 347SI and RW 1.4551

Packaging forms

White carton boxes of 5 kg.

Red, white or blue coloured cardboard tubes of 5 kg.

Wooden crates of 250 kg.