

OK Tigrod 347Si

Bare corrosion resisting chromium-nickel rods for welding of austenitic chromium nickel alloys of 18 % Cr-8 % Ni-type. OK Tigrod 347Si has a good general corrosion resistance. The alloy is stabilized with Niobium to improve the resistance against intergranular corrosion of the weld metal. The higher silicon content improves the welding properties, such as wetting. Due to the niobium content this alloy is recommended for use at higher temperatures.

Specifications

Classifications	EN ISO 14343-A : W 19 9 Nb Si SFA/AWS A5.9 : ER347Si Werkstoffnummer : ~1.4550
Approvals	CE : EN 13479 NAKS/HAKC : 1.6 mm - 2.4 mm VdTÜV : 09736

Approvals are based on factory location. Please contact ESAB for more information.

Alloy Type	Austenitic (with approx. 8 % ferrite) 19% Cr - 9% Ni - Nb
Shielding Gas	I1 (EN ISO 14175)

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
As Welded	440 MPa (64 ksi)	640 MPa (93 ksi)	35 %

Typical Charpy V-Notch Properties

Testing Temperature	Impact Value
20 °C (68 °F)	90 J (66 ft-lb)
-60 °C (-76 °F)	75 J (55 ft-lb)

Typical Wire Composition %

C	Mn	Si	Ni	Cr	Mo	Cu	Nb
0.04	1.7	0.7	9.8	19	0.1	0.10	0.60

Typical Weld Metal Analysis %

C	Mn	Si	S	P	Ni	Cr	Mo	Cu	Nb
0.04	1.5	0.8	0.01	0.02	10	20	0.1	0.1	0.7