

OK Autrod 347

A continuous solid corrosion resisting chromium-nickel wire for the welding of austenitic chromium nickel alloys of the 18% Cr - 8% Ni-type. OK Autrod 347 has a good general corrosion resistance. The alloy is stabilized with Niobium to improve the resistance against intergranular corrosion of the weld metal. Due to the niobium content this alloy is recommended for use at higher temperatures. OK Autrod 347 can be used in combination with OK Flux 10.92, OK Flux 10.93 and OK Flux 10.94.

Specifications

Classifications	EN ISO 14343-A : S 19 9 Nb SFA/AWS A5.9 : ER347
Approvals	CE : EN 13479 DB : 52.039.07 NAKS/HAKC : 2.4 - 4.0 mm UKCA : EN 13479 VdTÜV : 12101

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

Alloy Type	Austenitic (with approx. 10 % ferrite) 19% Cr - 9% Ni - Nb
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Typical Wire Composition %

C	Mn	Si	Ni	Cr	N	Nb	FN WRC-92
0.04	1.4	0.4	9.5	19.2	0.05	0.6	7