

OK Tigrod 347

Bare corrosion resisting chromium-nickel rods for welding of stabilized austenitic chromium nickel alloys of 18% Cr - 8% Ni-type. The rods are stabilized with Niobium, which gives a good resistance to intergranular corrosion of the weld metal. Due to the niobium content this alloy is recommended for use at higher temperatures.

Specifications

Classifications	EN ISO 14343-A : W 19 9 Nb SFA/AWS A5.9 : ER347 Werkstoffnummer : ~1.4550
Approvals	CE : EN 13479 UKCA : EN 13479 VdTÜV : 19918

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)

Tensile Properties

Testing Condition	Yield Strength	Tensile Strength	Elongation
As Welded	510 MPa	655 MPa	35 %

Charpy Testing

Testing Condition	Testing Temp	Impact Value
As Welded	20 °C	130 J

Typical Weld Metal Analysis %

C	Mn	Si	S	P	Ni	Cr	Mo	V	Al
0.04	1.3	0.4	0.009	0.016	9.2	18.8	0.1	0.05	0.002

Typical Weld Metal Analysis %

Cu	N	Nb	Ti	Co	FN WRC-92
0.1	0.06	0.6	0.003	0.1	8

Typical Wire Composition %

C	Mn	Si	S	P	Ni	Cr	Mo	Cu	N
0.04	1.4	0.39	0.013	0.014	9.4	19.3	0.1	0.1	0.05

Typical Wire Composition %

Nb	FN WRC-92
0.7	8