GMAW Solid Wire for Stainless Steel

KMS-347Si

Shielding Gas: Ar+1~2%O_2(CO_2)

Classification

AWS	A5.9/A5.9M	ER347Si
JIS	Z3321	YS347Si
EN	14343-A	G 19 9 Nb Si
YB	T5092	H03Cr20Ni10SiNb

Applications and Features

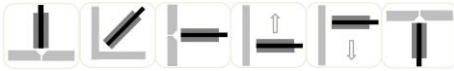
(1) Weld metal is austenitic structure with 19%Cr-9%Ni-Nb.

(2) The addition of niobium reduces intergranular corrosion in severe operating conditions.

(3) High silicon level for increased puddle fluidity and toe wetting.

(4) Ideal for welding AISI 308H, 321 and 347 stainless steel plates.

Welding Position



Welding Instruction

(1) Use Ar+1~2%O_2 for spray transfer and Ar+1~2%CO_2 for short-circuit transfer.

(2) For other instructions, please refer to Appendix B and F.

Typical Chemical Composition of Weld Metal (wt%)

C	Si	Mn	P	S	Cr	Ni	Nb
0.04	0.78	1.60	0.010	0.010	20.31	9.83	0.76

Typical Mechanical Properties of Weld Metal

Tensile Strength N/mm^2	Yield Strength N/mm^2	Elongation %
620	450	42

Size and Suggested Operating Range (DC+)

Diameter (mm)		0.8	0.9	1.0	1.2	1.4	1.6
Ar+1~2%CO_2	Current (A)	40~120	60~140	80~160	100~210	-	-
	Voltage (V)	15~20	15~21	16~22	17~22	-	-
Ar+1~2%O_2	Current (A)	160~210	170~260	180~280	200~300	210~320	220~330
	Voltage (V)	24~28	24~30	24~30	24~30	24~32	24~32