

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.

Classifications Wire Electrode	SFA/AWS A5.9 : ER347Si EN ISO 14343-A : W 19 9 Nb Si Werkstoffnummer : ~1.4551
Approvals	NAKS/HAKC 1.6 mm - 2.4 mm VdTUV 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 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 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

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