Exaton 347

347 is suitable for joining stainless steels of the 18Cr/8Ni/Nb and 18Cr/8Ni/Ti types. Due to the strenghtening effect of niobium, this grade is recommended if the weld metal will be exposed to temperatures above 400°C (750°F). It is used for TIG-welding.

Classifications Wire Electrode	SFA/AWS A5.9 : ER347 EN ISO 14343-A : W 19 9 Nb EN 10088-1 : ~1.4550
Approvals	CE EN 13479 VdTÜV 00068

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

Shielding Gas	I1 (EN ISO 14175)

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
As Welded	20 °C (68 °F)	135 J (100 ft-lb)
As Welded	-30 °C (-22 °F)	120 J (89 ft-lb)
As Welded	-140 °C (-220 °F)	60 J (44 ft-lb)

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	V	Al
0.05	1.4	0.4	0.013	0.015	9.3	19.2	0.1	0.04	0.002

Typical Wire Composition %

Cu	N	Nb	Ti	Co	FN WRC-92
0.1	0.05	0.7	0.003	0.1	7

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