

## Exaton 347

347 is suitable for joining stainless steels of the 18Cr/8Ni/Nb and 18Cr/8Ni/Ti types. Due to the strengthening 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 MIG/MAG welding.

<b>Classifications Wire Electrode</b>	SFA/AWS A5.9 : ER347 EN ISO 14343-A : G 19 9 Nb EN 10088-1 : ~1.4550
<b>Approvals</b>	CE EN 13479 VdTUV 00069

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

<b>Shielding Gas</b>	M12, M13 (EN ISO 14175)
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### Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
As Welded	20 °C (68 °F)	90 J (67 ft-lb)
As Welded	-196 °C (-321 °F)	30 J (22 ft-lb)

### Typical Weld Metal Analysis %

C	Mn	Si	S	P	Ni	Cr	Mo	V	Al
0.06	1.5	0.4	0.012	0.016	9.2	19.2	0.1	0.06	0.003

### Typical Weld Metal Analysis %

Cu	N	Nb	Ti	Co	FN WRC-92
0.1	0.04	0.7	0.003	0.1	9

### 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

### Recommended Welding Parameters

Wire Diameter	Current	Voltage	Wire Feed Speed
1.0 mm (0.040 in.)	60-220 A	15-28 V	4.0-12.0 m/min (157-472 in./min)
1.2 mm (0.047 in.)	150-260 A	24-29 V	3.0-10.0 m/min (118-394 in./min)