

PRODUCT DATA SHEET

TIG WIRE - PROWELD - 347Si/ (1.4551)

Classification: AWS / ASME – A/ SFA 5.9 ER 347Si
BS EN 14343: 2007 – W19.9. Nb

Typical Applications:

Proweld 347Si is primarily used for welding stabilized austenitic stainless steel of type 321 and 347 This can be also used for welding austenitic stainless steel of type 304L/1.4306, 304/1.4301.

The higher silicon content gives better arc stability and weld fluidity. .

Welding Parameters

The information will be provided on request.

Wire Composition: (%)

	C	Mn	Si	Cr	Ni	S	P	Mo
min	-	1.0	0.65	19.5	9	-	-	-
max	0.03	2.5	1.00	21.0	11	0.03	0.03	0.30

Shielding Gas:

I1 Pure Argon 5-10 L/min
M13 Argon+1-3% O₂, 5-10 L/min

Corrosion resistance:

Good resistance to general and intergranular corrosion at elevated temperature.

Mechanical properties (Typical as Weld):

Tensile Strength	610N/mm ²
Yield Strength	415 N/mm ²
Elongation A5	35%
Impact energy(20° C)	110J
-196°C	30 J
Hardness	190 BHN

Packaging Detail:

Diameter : 0.80,1.00,1.20,1.60, 2.0, 2.40,
3.20, 4.0 mm*

Length : 1000 mm (36")

Packing : 5 Kgs in Spiral Tubes/Plastic,
then in a Master Carton of 25
Kg(5x5)**

Also available in AWS standard diameters

Ferrite content:

Ferrite Number about 9 – WRC-92

Marking:

Both ends embossed with grade and diameter for the diameter >=1.60mm