

LNM 347Si

CLASSIFICATION

AWS A5.9	ER347Si	A-Nr	8	Mat-Nr	1.4551
ISO 14343-A	G 19 9 NbSi	F-Nr	6		
		9606 FM	5		

GENERAL DESCRIPTION

Solid wire for welding Ti or Nb stabilized stainless CrNi-steels
High resistance to intergranular corrosion and oxidizing environments

WELDING POSITIONS (ISO/ASME)



SHIELDING GASES (ACC. ISO 14175)

M12	Mixed gas Ar+ 0.5-5% CO ₂
M13	Mixed gas Ar+ 0.5-3% O ₂

APPROVALS

TÜV	DB
+	+

CHEMICAL COMPOSITION (W%) TYPICAL WIRE

C	Mn	Si	Cr	Ni	Mo	Nb
0.04	1.3	0.9	19.2	9.9	0.3	0.6

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

Typical values	Shielding gas	Condition	0.2% proof strength	Tensile strength	Elongation	Impact ISO-V(U)	
			(N/mm ²)	(N/mm ²)		+20°C	-196°C
	M12	AW	460	650	35	100	40

EXAMPLES OF MATERIALS TO BE WELDED

Steel grades	EN 10088-1/-2	EN 10213-4	Mat. Nr	ASTM/ACI A240/A312/A351	UNS
Ti-,Nb stabilized					
	X6CrNiTi18-10		1.4541	(TP)321 (TP)321H	S32100 S32109
	X6CrNiNb18-10		1.4550	(TP)347 (TP)347h	S34700 S34709
		GX5 CrNiNb 19-10	1.4552	CF-8C	J92710
Non stabilized					
	X4CrNi18-10		1.4301	302 (TP)304	S30400
	X2CrNi19-11		1.4306	(TP)304L	S30403
		GX5 CrNi 19-10	1.4308	CF-8	J92600
			1.4312	(TP)304H	S30409

PACKAGING AND AVAILABLE SIZES

Diameter (mm)	0.8	1.0	1.2
15 kg spool BS300	X	X	X

Other sizes and packaging on request

LNM 347Si :rev. C-EN24-28/08/20