

OK Autrod 347Si

A continuous, solid, corrosion-resistant, chromium-nickel wire for welding austenitic chromium-nickel alloys of the 18% Cr-8% Ni type. OK Autrod 347Si has good general corrosion resistance. The alloy is stabilised with niobium to improve resistance to the 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:	EN ISO 14343-A:G 19 9 Nb Si, SFA/AWS A5.9:ER347Si, Werkstoffnummer :~1.4551
Approvals:	CE EN 13479, VdTÜV 09734, NAKS/HAKC 1.0MM-1.2MM, DB 43.039.13

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

Alloy Type:	Austenitic (with approx. 8 % ferrite) 19% Cr - 9% Ni - Nb
--------------------	---

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
As welded	440 MPa	640 MPa	37 %
Tested at 400\00B0C.			
As welded	340 MPa	460 MPa	26 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
As welded	20 °C	110 J
As welded	-60 °C	80 J

Typical Wire Composition %

C	Mn	Si	Ni	Cr	Mo	Cu	Nb	Ferrite FN
0.04	1.7	0.7	9.8	19	0.1	0.10	0.60	7

Deposition Data

Diameter	Current	Voltage	Wire Feed Speed	Deposition Rate
0.8 mm	55-160 A	15-24 V	4.0-17.0 m/min	1.0-4.1 kg/h
1.0 mm	80-240 A	15-28 V	3.5-18.0 m/min	1.5-6.0 kg/h
1.2 mm	100-300 A	15-29 V	3.0-14.0 m/min	1.6-7.5 kg/h
1.6 mm	230-375 A	23-31 V	5.5-9.0 m/min	5.2-8.6 kg/h