TECHNICAL DATA SHEET

Super6 347 MIG

AWS A 5.9 : ER 347Si
EN ISO 14343-A : G 19.9 Nb Si
Date 20.05.24 Revision 1

DESCRIPTION

Super6 347Si is used for welding 321 and 347 grade stainless steel. The wire is suitable for a range of applications including pipe, plate and vessel fabrications. The weld metal has a high resistance to corrosive media at service temperatures < 400°C. The presence of niobium reduces the propensity of intergranular chromium carbide precipitation and reduces the susceptibility of intergranular corrosion. Increased silicon results in better pool fluidity giving a smooth appearance.

WELDING POSITIONS

PA, PB, PC, PF, PE, PF2

CHEMICAL COMPOSITIONS

C	Mn	Si	Cr	Ni
0.080 MAX	1.60 2.50	0.65 1.00	19.00 21.50	9.00 11.00

MECHANICAL PROPERTIES

Yield Strength	≥ 400
UTS N/mm²	≥ 550
Elongation A5 %	≥ 30%

AVAILABLE FORMATS

SPOOL		
Diameter	15kg	
0.8mm	7180	
1.0mm	7181	

Shielding Gas	EN ISO 14175 : M12,M13
Current Type	DC +

TECHNICAL DATA SHEET

Super6 347 TIG

AWS A 5.9 : ER 347
EN ISO 14343-A : W 19.9 Nb
Date 20.05.24 Revision 1

DESCRIPTION

Super6 347 is a solid tig wire depositing a niobium stabilized 19Cr 9Ni weld metal ,used for welding 321 and 347 grade stainless steel. The wire is suitable for a range of applications including pipe, plate and vessel fabrications. The weld metal has a high resistance to corrosive media at service temperatures < 400°C.

WELDING POSITIONS

PA, PB, PC, PG, PF, PE, PG2, PF2

CHEMICAL COMPOSITIONS

C	Mn	Si	Cr	Ni
0.08 MAX	1.50 2.20	0.30 0.65	19.00 21.50	9.00 11.00

MECHANICAL PROPERTIES

Yield Strength	≥ 400
UTS N/mm²	≥ 550
Elongation A5 %	≥ 30%

AVAILABLE FORMATS

TUBE		
Diameter	5.0KG	
1.6mm	7213	
2.4mm	7214	
3.2mm	7215	

Shielding Gas	Argon
Current Type	DC -