

## MIG Wire for Welding of Austenitic Stainless Steels

### Classification

AWS A5.9 : ER347Si  
ISO 14343-A : G 19 9 3 NbSi

### General Description

Solid wire for welding Ti or Nb stabilized austenitic type stainless CrNi-steels.  
High resistance to intergranular corrosion and oxidizing environments.  
With increased silicon for improved wettability.

### Chemical Composition (w%), Typical, Wire

C	Si	Mn	Cr	Ni	Mo	Nb	P + S
0.04	0.90	1.30	19.5	10	0.30	0.60	<0.035

### Mechanical Properties, Typical, All Weld Metal

Yield Strength : 460 N/mm<sup>2</sup>  
Tensile Strength : 650 N/mm<sup>2</sup>  
Elongation (L=5d) : 35 %  
Impact ISO-V : 100 J (+20°C)

### Shielding Gases (acc. ISO 14175 and EN 439)

MIG : M12 - Ar + 1 - 5 % CO<sub>2</sub>  
M13 - Ar + 1.5 - 3 % O<sub>2</sub>

### Materials to be Welded

	EN 10088-1/-2	EN 10213-4	Mat. Nr.
<b>Ti/Nb Stabilized</b>	X6 CrNiTi 18 10		1.4541
	X6 CrNiNb 18 10		1.4550
	X8 CrNiTi 18 10		1.4878
		G-X5 CrNiNb 19 10	1.4552
<b>Non Stabilized</b>	X2 CrNi 19 11		
	X2 CrNiN 18 10		1.4306
	X4 CrNi 18 10		1.4311
			1.4301
		G-X5 CrNi 19 10	1.4308

### Packaging and Available Sizes

Diameter	0.8	1.0	1.2	1.6	2.0	2.4	3.2	Spool Weight
MIG Wire	-	X	X	X	-	-	-	12.5 kg