

LNM 347Si

CLASSIFICATION







AWS A5.9 - ER347Si

ISO 14343-A -G 19 9 NbSi

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						
	PA/TG	PB/2F	PC/2G	PD/4F	PE/4G	PF/3G up

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
0.05	1.4	0.7	19.2	9.9	0.1	0.6

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

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

MATERIALS TO BE WELDED

Steel grades	EN 10088-1/-2	EN 10213-4	Mat. Nr	ASTM/ACI A240/A312/A351	UNS
Ti-,Nb stabilized					
	X6CrNiTi 18-10		1.4541	(TP)321	S32100
				(TP)321H	S32109
	X6 CrNiNb 18-10		1.4550	(TP)347	S34700
				(TP)347h	S34709
Non stabilized		GX5 CrNiNb 19-10	1.4552	CF-8C	J92710
				302	
	X4 CrNi 18-10		1.4301	(TP)304	S30400
	X2 CrNi 19-11		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
Unit : 15 kg spool BS300	X	X	X

Other sizes and packaging on request

LNM 347Si rev. EN 23