

Standards

TS EN ISO 14343-A	: G 19 9 Nb Si
EN ISO 14343-A	: G 19 9 Nb Si
AWS A5.9	: ER 347 Si

Chemical Composition of Welding Wire % (Typical)

C	Si	Mn	Cr	Ni	Nb
0.035	0.9	1.2	19.4	9.7	+

Mechanical Properties

Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Impact Strength (ISO-V/+20°C)	Elongation ((L ₀ =5d ₀) (%))
min. 400	570- 710	min. 63 J	min. 30

Typical Base Material Grades

- X6 CrNiNb 18 10, X6 CrNiTi 18 10, G-X5 CrNiNb 18 9, X5 CrNi 18 10, G-X 10 CrNi 18 8, X12 CrNiTi 18 9, X10 CrNiNb 18 10
- AISI & ASTM: 304, 321, 347, A157Gr.C9, A296Gr.CF8C, A320Gr.B8C, A320Gr.B8D

Features and Applications

- Used for the welding of 13% Cr steels which are used in the textile, paper, paint and food industries
- Resistant to corrosion up to +400°C, suitable for MIG welding
- Ar+ %2.5 O₂ or Ar+ %2.5 CO₂ mixed gases are used for shielding, also used for the welding of materials which have the similar chemical composition to welding wire

Welding Positions



Current Type

MIG D.C.(+)

Operating Data

Product Code	Diameter (mm) / (inch)		Weight (Kg)	Package Type
	mm	inch		
6011100359	1.0	0.040"	15	BS 300
6011100231	1.2	0.047"	15	BS 300

Approvals: CE, SEPRO