



Nevatia Steel & Alloys Pvt. Ltd.  
Office : 904,Lodha Supremus,9<sup>th</sup> floor  
Worli, Mumbai ,India - 400018.  
Web:<http://www.nevatiasteel.com>



TD-Stainless Welding wire  
Revision No.: 02  
Date of Issue : 01.11.2019

IATF 16949 , ISO 9001, ISO 14000 and ISO 45001 Certified Company

## **Stainless steel welding wire -Technical data**

**Product Name :** nevinox<sup>®</sup>MIG347

**Product Specifications :** ER 347

Grade	Equivalent Standards		
	AWS A5.9/5.9M	EN ISO 14343 A	EN ISO 14343 B
ER 347	ER 347	19 9 Nb	347

**Characteristics :** ER347 are Niobium stabilized 18Cr-8Ni type welding wires are designed to produce excellent weld appeal with Argon+O<sub>2</sub> or CO<sub>2</sub> mixtures as shielding gas.

**Application :** ER 347 is Niobium stabilized grades are suitable for MIG/TIG welding of type AISI 321 and the 18/8 types which are likely to be subject to temperatures of above 400°C but not more than 850°C.

### **Chemical Composition % (Solid wire)**

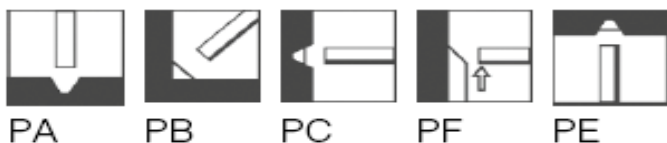
C	Mn	P	S	Si	Cr	Ni	Mo	Cu	Nb
0.08	1.30 - 2.10	0.030	0.020	0.30 - 0.65	19.00 - 21.00	9.00 - 11.00	0.30	0.30	10xC - 1.00

**Remarks:** Single values shown in the table are maximum values. Two values shown indicate minimum and maximum limits for a range.

**Current Conditions:-** DC (+)

**SHIELDING GAS:** welding with 100% Ar gas Or Ar+2%O<sub>2</sub> gas.

**Welding position: -**



PA PB PC PF PE



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## Dimension & Packing Data

Size(mm)	Size(inch)	SD100 Spool packing 1kg/2lb	SD200Spool packing 5kg/10lb	SD300/BS300 Spool packing 12.5kg,15kg /25lb, 33lb	Drum packing 100kg,250kg/ 200lb, -550 lb
0.600	0.024	√	√	-	-
0.800	0.030	√	√	√	√
0.900	0.035	√	√	√	√
1.000	0.040	√	√	√	√
1.200	0.045	√	√	√	√
1.600	0.063	-	√	√	√

## Diameter tolerance and ovality

- As per AWS A5.9 and ISO 544

## Inspection & certification

- As per EN 10204 type 3.1

**For more details please contact : [sales@nevatiasteel.com](mailto:sales@nevatiasteel.com).**