



Nevatia Steel & Alloys Pvt. Ltd.
Office : 904, Lodha Supremus, 9th 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[®]TIG347

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+O₂ or CO₂ 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.

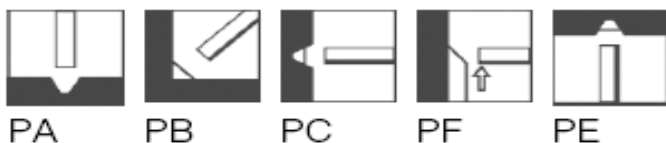
Chemical Composition % (Solid wire)

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 (-)

Welding position: -



PA PB PC PF PE



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Dimension & Packing Data

Size(mm)	Size(inch)	Length (mm)	Length (inch)	Tube packing 5 kg/10lb	Box packing 20/25 kg / 50 lb
0.90	0.035	1000	36"	√	√
1.00	0.040	1000	36"	√	√
1.20	0.045	1000	36"	√	√
1.60	1/ 16"	1000	36"	√	√
2.00	5/ 64"	1000	36"	√	√
2.40/2.50	3/ 32"	1000	36"	√	√
3.15/3.20	1/ 8"	1000	36"	√	√
4.00	5/ 32"	1000	36"	√	√
5.00	3/ 16"	1000	36"	√	√

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.