



# MIG 347Si sadevinox

## Standards

AWS 5.9	EN ISO 14343-A	W. Nr.
<b>ER 347Si</b>	<b>G 19 9 NbSi</b>	<b>1.4551</b>

## Description & applications

Filler metal in solid wire spools for MIG welding of austenitic stainless steels without Molybdenum. Grade 347Si is stabilized with Niobium to prevent intergranular corrosion in weldments; the high Silicon content improves the wettability of the molten metal.

Niobium also increases creep resistance up to 400 °C.

## Typical chemical composition (%)

C max	Mn	Si	Cr	Ni	Nb	S max	P max	Fe
<b>0.03</b>	<b>1.5</b>	<b>0.85</b>	<b>19.5</b>	<b>9.5</b>	<b>0,45</b>	<b>0.02</b>	<b>0.02</b>	<b>Base</b>

## Typical mechanical properties of all-weld metal

Rm	Rp 0,2	A5	KV -196°C
<b>620 MPa</b>	<b>410 Mpa</b>	<b>35 %</b>	<b>45 J</b>

## Operating parameters

### Shielding gas recommendations :

EN ISO 14175 M12 : Argon + 2-3% CO<sub>2</sub> or Argon + 1-2 % O<sub>2</sub> / 12-18 l/mn



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