



## EWB<sup>®</sup> – ER 347 MIG / TIG Welding Wires

### Classifications:

EN ISO 14343-B:2007 : SS 347  
AWS A5.9: ER347

Material No. 1.4551

### Typical Chemistry Composition of Weld Deposit:

C	Cr	Ni	Mo	Mn	Si
<0.08	19.00 – 21.50	9.00 – 11.00	<0.75	1.00 - 2.50	0.30 – 0.65

### Description:

- MIG / TIG welding of 20%Cr-10%Ni-Nb austenite stainless steels (AISI STS 347, 321)

### Typical Mechanical Properties:

Yield Strength (Mpa)	Tensile Strength (Mpa)	Elongation (%)
min. 350	min. 520	min. 30

### Welding Parameters:

Wire Diameter (Ø in mm)	0.80	1.00	1.20
Pulsed Arc (A)	100 - 150	120 - 200	140 - 220
Voltage (V)	22 - 27	24 - 28	24 - 28

### Packing Available:-

**MIG/MAG Wire** (Ø in mm): 0.80 / 1.00 / 1.20

**TIG Wire** (Ø in mm): 1.60 / 2.40 / 3.20 / 4.00

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### EWB Weld

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