

INERTFIL 347

MIG-MAG Wires Stainless and Heat resistant steels

Inertfil 347 is a stainless steel solid wire suitable for welding stabilised austenitic steels such as AISI 321 and 347. Nb+Ta additions improve the oxidation resistance of the weld deposit.

Classification	
AWS	A5.9: ER 347
EN	12072: G 19 9Nb

Approvals	Grades
DB	
TÜV	

see Appendix, Classification Society Approvals, for details pag. 521

Analysis of all-weld metal (Typical values in %)

C	Mn	Si	P	S	Cr	Ni	Mo	Nb	Cu	N	Ferrite
0.06	1.60	0.45	≤ 0.030	≤ 0.030	19.50	10	-	0.80	-	-	5-10

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation A5 (%)	Impact Energy ISO - V (J) 20°C	Hardness
As Welded	≥ 400	≥ 550	≥ 30	≥ 47	-

Gas test: Acc. To EN 439: M13(Cargal1)

Shielding Gas: Acc. To EN 439: M13(Cargal1)

Materials

1.4541 (X6CrNiTi18-10); 1.4301 (X4CrNi18-10); 1.4550 (X6CrNiNb18-10);
AISI 347 - 321

Storage

Keep dry and avoid condensation

Current condition and welding position

DC+				
				
PA	PB	PC	PF	PE

Packaging data: BS300 Kg. 15

Diameters	0,8	1,0	1,2			
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