

INERTROD 347

TIG Rods Stainless and Heat resistant steels

Inertrod 347 is a stainless TIG rod suitable for welding stabilized austenitic stainless steels such as AISI 321 and 347. The Nb addition considerably improves 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: I1(Arcal1)

Shielding Gas: Acc. To EN 439: I1(Arcal1)

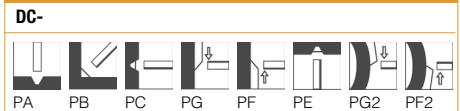
Materials

1.4541 (X6CrNiTi18-10); 1.4301 (X4CrNi18-10); 1.4550 (X6CrNiNb18-10); 1.4551
AISI 347 - 321

Storage

Keep dry and avoid condensation

Current condition and welding position



Packaging data: Tube 5 kg

Diameters (L: 1000 mm)	1,0	1,2	1,6	2,0	2,4	3,2

Further forms of delivery on request.