



S. R. Industries

STAR ARC ER347

ER347 is a stainless steel welding wire used in joining types 321 and 347 grades of stainless. The addition of columbium to this alloy reduces the possibility of chromium carbide precipitation and consequent intergranular corrosion.

AWS Specification : AWS A5.9/A5.9M:2006

AWS Classification	ER347
Welding Current	DCEP
Typical Wire Chemistry	
C	0.08
Cr	19.0 - 21.5
Ni	9.0 - 11.0
Mo	0.75
Mn	1.0 - 2.5
Si	0.30 - 0.65
P	0.03
S	0.03
Cu	0.75
Nb	10xCmin/1.0max
Typical Mechanical Properties (As Welded)	
Yield Strength, ksi	57
Tensile Strength, ksi	86
Elongation%, min	35
Welding Positions	F,V,OH,H

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<i>Available Diameters MIG with Operating Range in Amps</i>	
.023"	35 - 70
.030"	50 - 100
.035"	160 - 210
.045"	180 - 250
<i>Available Diameters TIG with Operating Range in Amps</i>	
.035"	60 - 90
.045"	80 - 110
1/16"	90 - 130
3/32"	120 - 175
1/8"	150 - 220
5/32"	170 - 350

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