



## FW 347 Si

**CODIFICATION:** AWS : SFA 5.9 ER347Si

### CHARACTERISTICS AND APPLICATIONS:

FW 347 Si is a solid wire for TIG welding, available in bright finish, gives smooth flow, stable arc and spatter free under optimum welding conditions. It gives radiographic quality weld deposit. The Nb reduces the possibility of intergranular chromium carbide precipitation and thus susceptibility to intergranular corrosion and high temperature strength. Silicon improves the usability of the filler metal. It is suitable for welding Cr-Ni stabilized stainless steels of type AISI 347, 321, etc.

### TYPICAL CHEMICAL COMPOSITION OF SOLID WIRE:

Element	C	Mn	Si	S	P	Cr	Ni	Nb
Percent	0.04	1.40	0.90	0.010	0.015	19.20	9.50	0.55

### TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL:

UTS	Elongation
(MPa)	(L = 4d) %
580	33.0

**SHIELDING GAS:** Argon

**CURRENT CONDITIONS:** DCEN

**WELDING POSITIONS:** H, F, VU, OH

### PACKING:

**STANDARD SIZE:** Diameter 1.6 mm, 2.0 mm, 2.4 mm & 3.2 mm in cut lengths of 1000 mm each.

**QUANTITY** 5 kgs wire put in an air-tight polythene bag and finally packed in a plastic container.  
Identification – AWS code is punched on each wire.