
 <p>Complete Welding Support</p>	<h2>Autotherme Grade -347 (SAW Wire)</h2>	
	<p>Autotherme Grade-347 is an Niobium Stabilized 18Cr8Ni type corrosion resistance SAW Wire</p>	

CLASSIFICATION: AWS: SFA 5.9
ER347

CHARACTERISTICS & APPLICATIONS:

Autotherme Gr. 347 continuous, solid corrosion-resistant, chromium nickel wire for welding austenitic chromium nickel alloys of the 18% Cr-8% Ni type. Autotherme Grade-347 has good general corrosion resistance. The alloy is stabilized with niobium to improve resistance to the Intergranular corrosion of the weld metal. Due to the niobium content, this alloy is recommended for use at higher temperatures. This wire can be used in combination with Maxflux SS-4.

CHEMICAL COMPOSITION OF SOLID WIRE, WT. %:

Element	C	Mn	Si	S	P	Cr	Ni	Cu	Nb
Typical	0.07	1.5	0.52	0.010	0.012	19.5	9.5	0.10	0.45
Range	0.08 Max	1.0- 2.5	0.30- 0.65	0.03 max	0.03 max	19.0- 21.5	9.0- 11.0	0.75 max	10xC min- 1.0 max

CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, WT. %:

MAXFLUX	Element	C	Mn	Si	S	P	Cr	Ni	Cu	Nb
SS4	Typical	0.07	1.52	0.55	0.010	0.012	20.0	9.5	0.10	0.70

MECHANICAL PROPERTIES OF WELD METAL:

MAXFLUX	Property	UTS (MPa)	EI (L=4d) (%)
SS4	Typical	540	32

PACKING:	STANDARD SIZE	Diameter 2.5mm, 3.2mm & 4.0 mm
	QUANTITY	<ul style="list-style-type: none"> ➤ 25 kg. Wire in metallic ring. ➤ Identification-Brand name & size is printed on label. ➤ Packed in corrugated cardboard box.

An ISO 9001: 2008 COMPANY

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