

GM 347



DESCRIPTION : ER 347

CLASSIFICATION : A niobium Stabilised stainless steel MIG wire of 19/10 type for GMAW welding.

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A niobium Stabilised stainless steel MIG wire of 19/10 type for GMAW welding.

WELDING PROPERTIES:

GM-347 is niobium Stabilised stainless steel wire of 20% Cr 10% Ni type for GMAW welding smooth flow and shiny bead. The weld deposit is free from cracks.

The deposited weld metal is of radiographic quality.

TYPICAL USES :

GM 347 is suitable for AISI 321, 347 and 348 type grade that are commonly used in refinery, chemical, and petrochemical industries, food & beverage industries etc.

WELDING CURRENT : DC(-)

COMPOSITION OF THE WIRE (RANGE) %:

C	Ni	Mn	Si	Nb
0.070 max	9.0-11.0	1.0-2.5	0.30-0.60	%Cx8 minor 0.95 max
Cr	S	P	Cu	Mo
19.0-21.5	0.03 max	0.03max	0.50max	0.50max

MECHANICAL PROPERTIES (RANGE) :

Tensile Strength N/mm ²	Yield Stress N/mm ²	Elongation(%) (L=4D)
550-650	400-500	30-45

SHIELDING GAS : Ar + 2 % O₂, 16-21 l/min Ar + 1 - 3 % CO₂, 16-21 l/min

PACKING DATA :

SIZE (mm)	Wt.of the spool (Dia.of spool : 300 mm layer to layer winding) KG (approx)
0.80	12.50
1.00	12.50
1.20	12.50
1.60	12.50