



## Nexus 347/347Si

19Cr 9Ni Niobium stabilised solid Stainless Steel wires for MIG and TIG welding applications

Austenitic 347 Niobium stabilised MIG/TIG wires for joining and overlaying materials of similar compositions. The 347Si MIG wire has higher Silicon level which increases weld pool fluidity, producing mitre finish fillet welds with good toe blending and improved spatter levels.

### International Standards

	<b>ISO 14343 - A - :2007</b>	<b>AWS A5.9-93</b>
<b>347</b>	<b>W 19 9 Nb</b>	<b>ER 347</b>
<b>347Si</b>	<b>G 19 9 Nb Si</b>	<b>ER 347Si</b>

### Typical All-Weld Metal Analysis (wt%)

	<b>C</b>	<b>Si</b>	<b>Mn</b>	<b>S</b>	<b>P</b>	<b>Cr</b>	<b>Ni</b>
<b>347</b>	<b>0.02</b>	<b>0.45</b>	<b>1.95</b>	<b>0.01</b>	<b>0.015</b>	<b>20.0</b>	<b>10.0</b>
<b>347Si</b>	<b>0.045</b>	<b>0.85</b>	<b>2.0</b>	<b>0.02</b>	<b>0.025</b>	<b>19.5</b>	<b>9.75</b>

### Typical All-Weld Metal Mechanical Properties

	<b>Yield Strength N/mm<sup>2</sup></b>	<b>Tensile Strength N/mm<sup>2</sup></b>	<b>Elongation %</b>	<b>Impact Strength 20<sup>0</sup>C</b>
<b>347</b>	<b>~490</b>	<b>~660</b>	<b>~35</b>	<b>~140</b>
<b>347Si</b>	<b>&gt;500</b>	<b>~670</b>	<b>~35</b>	<b>~140</b>

### Welding Positions

<b>All Positions including vertical down</b>
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### Materials

<b>AISI 321 and 347</b>
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### Packaging

<b>Size mm</b>	<b>1.6</b>	<b>2.4</b>	<b>3.2</b>
<b>Plastic 5 kilo Tube</b>	<b>✓</b>	<b>✓</b>	<b>✓</b>

<b>Size mm</b>	<b>0.8</b>	<b>1.0</b>	<b>1.2</b>
<b>Metal spools 15 kilo</b>	<b>✓</b>	<b>✓</b>	<b>✓</b>

### Additional Information

<b>Certification</b>	<b>BS EN 10204:2004 Type 3.1</b>
<b>Material safety data sheet</b>	<b>MSDS 02</b>
<b>BOC Shielding Gas MIG</b>	<b>Stainshield Light (&lt;4mm) Universal (2-10mm) Heavy (&gt;9mm)</b>
<b>BOC Shielding Gas TIG</b>	<b>Pureshield Argon Stainshield TIG &lt;5mm</b>