



WB347M M.I.G. WELDING WIRE

Classifications	AWS A5.9-81 : ER347 BSEN12072-00 : G19 9Nb									
Product Description	347 stainless steel, solid MIG wire.									
Applications	<p>WB347M is suitable for the repair and welding of 304, 321 and 327 Niobium stabilised stainless steels to give freedom from intergranular attack.</p> <p>Typical grades include:- wrought BS321S31, 347S31, BSEN 1.4541, 1.4550, ASTM/ASME 321, 347, DIN 1.4541, 1,4543, 1.4546, 1,4550. Cast 347C17, CF8C and 1.4552.</p> <p>Ferrite in the 3-8 FN range.</p>									
Wire Composition (Weight%)	C	Mn	Si	S	P	Cr	Ni	Mo	Cu	Nb
min.	-	1.0	0.30	-	-	19.0	9.0	-	-	10xC
max.	0.08	2.5	0.65	0.03	0.03	21.5	11.0	0.5	0.50	1.0
Typical All-Weld Metal Mechanical Properties	Ultimate Tensile Strength					N/mm ²		550 min.		
	Yield Stress/0.2% Proof Stress					N/mm ²		350 min.		
	Elongation on 5D					%		25 min.		
	Impact Energy CV @ 20°C as-welded					Joules		47 min.		

Wire Dia (mm)		0.6mm	0.8mm	1.0mm	1.2mm	1.6mm	2.4mm	3.2mm
Current Range (Amps)	min.	-	80	120	160	180	-	-
	max.	-	180	240	260	300	-	-
Volt Range (Volts)	min.	-	17	17	18	20	-	-
	max.	-	20	22	26	29	-	-
Packaging Information								
Kg Per Reel		-	1.0/15	15	15	15	-	-
Storage	Storage It is recommended that the WB range of wires are stored in a dry heated store at a minimum temperature of 18°C, and a maximum relative humidity of 60%.							
Gases	Gas Pure Argon or Argon + 2%O ₂ mixture Flow Rate 12-16 l/min							

Current Conditions DC+ and Welding Positions

