

MIDALLOY ER347 BARE WIRE

CLASSIFICATION

- AWS 5.9 Class ER347 / ASME SFA 5.9 Class ER347 UNS S34780

DESCRIPTION

- MIDALLOY ER347 bare welding wire is a stabilized austenitic stainless steel.

APPLICATIONS

- Typical applications include welding, repairing and overlaying of stabilized grades of stainless steel like type 347 and type 321.
- ER347 is used in the refinery industry to combat high temperature erosion corrosion and fatigue.
- Other welding applications include valves, valve seating surfaces , gears, propeller shafts, and impellers.
- Normally ER347 is normally used to weld AISI 321 since titanium will not transfer across the arc.

TYPICAL CHEMISTRY

C	Mn	Si	Cr	Ni	Mo	Cu	Cb*	S	P	Fe
.06	.144	.33	21.0	10.50	0.1	0,3	0.63	.021	.015	BAL.

* Cb is 10 times the carbon content to a maximum of 1.0%

TYPICAL MECHANICAL PROPERTIES*

TENSILE STRENGTH	78,000 PSI
YIELD STRENGTH	60,000 PSI
ELONGATION IN 2"	30%

WELDING PARAMETERS (see Page 2)

STANDARD PACKAGING

- TIG 10 lb. tube / 60 lb. carton
- MIG 30 lb. spool
- SAW 60 lb coils

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