

GM 347

IDENTIFICATION

GM 347, ER 347

CLASSIFICATION

AWS /SFA5.9 ER 347

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

CHEMICAL ANALYSIS (RANGE) %

C	Ni	Mn	Si	Nb	Cr	S	P	Cu	Mo
0.08 max	9.0 - 11.0	1.0 - 2.5	0.30 - 0.60	%C x 10 min or 0.95 max	19.0 - 21.5	0.03 max	0.03 max	0.50 max	0.50 max

MECHANICAL PROPERTIES (RANGE)

TS (MPa)	EL (%) (L=4D)
520 - 640	30 - 45

TYPICAL APPLICATIONS

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 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.

WELDING CURRENT : DC (-)

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

PACKING PARAMETERS

Size (mm)	Weight / Spool (kg)
0.8	12.5
1	12.5
1.2	12.5
1.6	12.5