

GM 347H

IDENTIFICATION

GM 347H, ER 347H

CLASSIFICATION

AWS /SFA5.9 ER-347H

DESCRIPTION

- A niobium stabilized, having controlled Carbon content stainless steel MIG wire of 19/10 type for GMAW welding.
- GM 347H are niobium Stabilised stainless steel wire having controlled Carbon 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.

CHEMICAL ANALYSIS (RANGE) %

| C | Ni | Mn | Si | Nb | Cr | S | P | Cu | Mo |
|-------------|------------|-----------|-------------|----------------------------|-------------|----------|----------|----------|----------|
| 0.04 - 0.08 | 9.0 - 11.0 | 1.0 - 2.5 | 0.30 - 0.60 | %Cx8 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 (N/mm ²) | EL (%) (L=4D) |
|-------------------------|---------------|
| 550 - 650 | 30 - 45 |

TYPICAL APPLICATIONS

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

SHIELDING GAS : 98% Ar + 1 - 2% Oxygen

PACKING PARAMETERS

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