



# Techalloy 347

## Description

Techalloy 347 is a niobium stabilized stainless steel welding wire used to weld Types 321 and 347. The addition of niobium reduces the possibility of chromium carbide precipitation and consequent inter-granular corrosion.

## Specifications & Approvals

AWS A5.9 ER347

UNS S34780

ISO 14343:2009 (19 9 Nb)

CWB

## Typical Chemical Composition

C	Mn	Si	Cr	Mo	Ni	Nb	N	S	P	Cu	FN (WRC)
.04	1.65	.52	19.9		9.75	.72		.005	.014		10

## Typical Mechanical Properties

Tensile Strength	86,500 PSI	600 MPA
Yield Strength	57,000 PSI	390 MPA
Elongation	35%	

## Welding Parameters

	Shielding	Gas Flow	Diameter	Voltage	Amperage
Mig Welding	98/99% Argon + 2/1% Oxygen 97% Argon + 3% CO2	30 to 50 CFH	.035" (0.9mm)	26 to 29	160/210
			.045" (1.14mm)	28 TO 32	180/250
			.062" (1.6mm))	29 TO 33	200/280
Tig Welding	100% Argon				
Sub Arc Welding	Suitable flux may be used		3/32" (2.5mm)	28 to 33	275/350
			1/8" (3.14mm)	29 TO 32	350/450
			5/32" (4.0mm)	30 TO 33	400/550

## Standard Packages:

Mig Wire– 33# wire basket	Tig Wire– 10# tube/30# Master Carton	SAW– 60# Coil
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