



AMA 30-15 T

Standards: AWS/ASME SFA-5.9

ER 347

Application/ Properties: Stabilized austenitic stainless welding rod for TIG welding of unstabilized corrosion resistant Cr Ni steels. Resistant to intergranular corrosion up to 400 C, non-scaling up to 800 C if subjected to air or oxidizing combustion gases.

Analysis of Wire electrode% (Typical value) :

C	Si	Cr	Ni	Nb
<0.08	0.3-0.65	19-21.5	9-11	>10xC

Shielding gas: 100% Ar.

Mechanical properties of all -weld metal :

Tensile Strength (N/mm ²)	0.2% Proof Stress (N/mm ²)	Elongation Lo = 4d %	Impact energy (j) (J) ISO - V 25 °C
>520	>350	>30	>65

Material:

DIN EN standard 1.4301 X5CrNi 18 10 ; 1.4541 X6CrNiTi 18 10 ; 1.4550 X6CrNiNb 18 10 ; 1.4303 X5CrNi 18 12 ; 1.4308 G-X6CrNi18 9 ; 1.4310 X12CrNi17 7 ; 1.4319 X5CrNi 18 7

other Standard AISI 347 ; 321 ; 302 ; 304 ; 304L ; 304LN ; ASTM A296 Gr. CF 8 C ; A157 Gr. C9 ; A320 Gr. B8C .

Delivery: welding rods

weight :5 kg.

diameter : 1-4 mm.

Length: 1000mm.

Note: other weight & sizes are produced upon customers request.

