

Solid Wire Electrode for MIG/MAG Welding

BA-MIG 347

Classification: EN ISO 14343-A: **G 19 9 Nb**
SFA-5.9: **ER347**

Main Application:

BA-MIG 347 is a solid wire electrode for GMAW, suitable to weld 18Cr/10Ni stabilized with Ti or Nb austenitic stainless steels grades 321 and 347. Also suitable for welding similar unstabilized grades 304 or 304L. BA-MIG 347 has high resistance to intergranular corrosion.

Typical analysis and chemical composition acc. to EN ISO 14343-A and AWS A5.9: (Weight Percent)

Wire electrode	C	Si	Mn	Mo	Ni	Cr	Nb	P	S	Cu total
Typical analysis BA-MIG 347	0.05	0.4	1.6	0.1	9.8	19.5	0.6	0.015	0.013	0.10
G 19 9 Nb acc. to ISO 14343-A	0.08	0.65	1.0-2.5	0.3	9.0- 11.0	19.0-21.0	10xC to 1.0	0.03	0.02	0.3
ER347 acc. to AWS A5.9	0.08	0.3-0.65	1.0-2.5	0.75	9.0- 11.0	19.0-21.5	10xC to 1.0	0.03	0.03	0.75

All - Weld Metal Mechanical Properties / Welding Data:

Heat Treatment	As Welded
Yield Strength Re, N/mm ² (ksi)	400 (58)
Tensile Strength Rm, N/mm ² (ksi)	550 (80)
Elongation A5 [%]	>28
Impact Energy ISO-V, J (ft lbs)	+20°C: 70 (52)
Current/polarity	DC +
Shielding Gas	ISO 14175: M13

Base Materials:

1.4550/ X6CrNiNb18-10, 1.4541/ X6CrNiTi18-10, 1.4552/ GX5CrNiNb19-11, 1.4301/ X5CrNi18-10, 1.4312/ GX10CrNi18-8, 1.4546/ X5CrNiNb18-10, 1.4311/ X2CrNi18-10, 1.4306/ X2CrNi19-11
AISI 347, 321, 302, 304, 304L, 304LN, ASTM A296 Gr. CF 8 C, A157 Gr. C9, A320 Gr. B8C or D

Package Forms:

Spools BS300/15 kg, D200/5 kg, and drums as standard package forms for GMAW wire electrodes.

Diameter:

0,8 – 1,6 mm. Sizes and tolerances acc. to ISO 544 and AWS A5.9.

Wire Electrode Surface:

Smooth finish free from surface defects and foreign matter.