

Solid Wire Electrode for Submerged Arc Welding

BA-WIRE 347

Classification: EN ISO 14343-A – S 19 9 Nb
SFA-5.9 – ER347

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-WIRE 347	0.05	0.4	1.4	0.1	9.8	19.5	0.60	0.015	0.014	0.1
S 19 9 Nb acc. to ISO 14343-A	0.08	0.65	1.0–2.5	0.5	9.0–11.0	19.0–21.0	10x%C >1.0	0.03	0.02	0.5
ER347 acc. to AWS A5.9	0.08	0.30–0.65	1.0–2.5	0.75	9.0–11.0	19.0–21.5	10x%C >1.0	0.03	0.03	0.75

Application:

BA-WIRE 347 is a submerged arc welding wire intended for welding Ti or Nb stabilized 18Cr/10Ni with corrosion-resistant austenitic stainless steels, grades 321 and 347. Also suitable for the welding of similar unstabilized grades 304 or 304L. BA-WIRE 347 has high resistance to intergranular corrosion.

Base Materials:

- 1.4550/X6CrNiNb18-10, 1.4541/X6CrNiTi18-10, 1.4552/GX5CrNiNb19-11, 1.4301/X5CrNi18-10, 1.4312/GX10Cr-Ni18-8, 1.4546/X5CrNiNb18-10, 1.4311/X2CrNi18-10, 1.4306/X2CrNi19-11
AISI 347, 321, 302, 304, 304L, 304LN, ASTM A296 grade CF 8 C, A157 grade C9, A320 grade B8C or D
Suitable flux: WP 380

Flux type suitability is strongly dependent on its application. In combination with the wire electrode the most suitable flux should match the requirements of the plate material as closely as possible under the existing welding conditions. Further information can be obtained from the technical flux data sheets.

Package forms:

Coils, spools, drums and spiders as standard package forms for SAW-wire electrodes, different package forms on request.

Diameter:

1.6 – 4.0 mm; sizes and tolerances acc. to ISO 544 and AWS A5.9.

Wire electrode surface:

Smooth finish free from surface defects and foreign matter.