

## OK Tigrod 347

Bare, corrosion-resistant, chromium-nickel rods for welding stabilised austenitic chromium-nickel alloys of the 18% Cr-8% Ni type. The rods are stabilised with niobium, which provides good resistance to the intergranular corrosion of the weld metal. Due to the niobium content, this alloy is recommended for use at higher temperatures.

<b>Classifications Wire Electrode</b>	SFA/AWS A5.9 : ER347 EN ISO 14343-A : W 19 9 Nb Werkstoffnummer : ~1.4551
<b>Approvals</b>	NAKS/HAKC 1.6-2.4 mm

*Approvals are based on factory location. Please contact ESAB for more information.*

<b>Alloy Type</b>	Austenitic (with approx. 8 % ferrite) 19% Cr - 9% Ni - Nb
<b>Shielding Gas</b>	I1 (EN ISO 14175)

### Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
As Welded	510 MPa (74 ksi)	655 MPa (95 ksi)	35 %

### Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
As Welded	20 °C (68 °F)	130 J (96 ft-lb)

### Typical Wire Composition %

C	Mn	Si	Ni	Cr	Mo	Cu	Nb
0.04	1.4	0.4	9.5	19.3	0.10	0.05	0.50