



**MANUFACTURERS OF A DIVERSE RANGE OF  
ADVANCED WELDING CONSUMABLES**

**SECTION  
13**

WI-0304 DS172 NSB-347R, Rev. 1, Date 02.01.2009

<b>NSB-347R</b>	<b>FILLER ROD FOR WELDING Nb or Ti STABILISED AUSTENITIC STAINLESS STEELS CONTAINING 19Cr AND 10Ni</b>					<b>DATA SHEET NO. 172</b>					
						SPECIFICATION	AWS A5.9	JIS Z 3321	BS EN 12072		
CLASSIFICATION	ER347	Y347	W 19 19 Nb								
WELD METAL ANALYSIS COMPOSITION % BY Wt.		C	Cr	Ni	Nb	Mn	Si	P	S	Cu	Fe
	MIN	-	19	9.0	8xC	1.0	0.30	-	-	-	
	MAX	0.08	21.5	11	1.0	2.5	0.65	0.03	0.03	0.75	
	TYPICAL	0.05	19.5	9.5	0.7	1.5	0.40	0.02	0.001	0.1	Bal.
WELD METAL PROPERTIES (ALL WELD METAL)	<u>PROPERTY</u>	<u>UNITS</u>	<u>MIN.</u>	<u>TYPICAL</u>	<u>OTHERS</u>						
	Tensile strength	N/mm <sup>2</sup>	510	650							
	0.2% Proof stress	N/mm <sup>2</sup>	320	460							
	Elongation on 4d	%	30	45							
	Impact energy -196 °C	J	-	60							
OTHER DATA	Argon mainly use as shielding gas										
RELATED PRODUCTS	Please contact our Technical Department for detail.										