

CWR-347 Welding Wire and Rod

CWR-347 is generally used for welding Cr-Ni stainless steel base metals of similar chemical composition stabilized with either Ti or Nb (Cb). The presence of Nb (Cb) minimizes the possibility of intergranular carbide precipitation and thus susceptibility to intergranular corrosion.

CONFORMANCES

AWS A5.9/A5.9M	:	ER 347
ASME SFA-A5.9	:	ER 347
ISO 14343-B	:	SS 347

AWS CHEMICAL COMPOSITION (TYPICAL)

%C	%Cr	%Ni	%Mo	%Mn
0.08 max 0.05	19.0 – 21.5 19.5	9.0 – 11.0 9.1	0.75 max 0.21	1.0 – 2.5 1.7
%Si	%P	%S	%Cu	%Nb+Ta
0.30 – 0.65 0.46	0.03 max 0.02	0.03 max 0.01	0.75 max 0.11	10xC – 1.0 0.6

TYPICAL WELD METAL MECHANICAL PROPERTIES

Yield Strength	:	58,000 psi
Tensile Strength	:	88,000 psi
Elongation (min.)	:	40 %

TYPICAL WELDING PARAMETERS

Process	Diameter		Voltage	Amperage	Gas/Flux
TIG (GTAW)	1/16"	1.6 mm	14 – 17	90 – 130	100% Ar
	3/32"	2.4 mm	15 – 20	120 – 175	100% Ar
MIG (GMAW)	.035"	0.9 mm	28 – 32	160 – 190	98%Ar – 2%O ₂
	.045"	1.1 mm	29 – 33	180 – 220	98%Ar – 2%O ₂
Sub Arc (SAW)	.093"	2.4 mm	28 – 32	250 – 450	
	.125"	3.2 mm	29 – 34	300 – 500	

*All parameters are suggested as basic guidelines only and will vary depending on joint design, number of passes and other factors.

<p>IMPORTANT: SPECIAL VENTILATION AND/OR EXHAUST REQUIRED</p> <p>BEFORE USE, READ AND UNDERSTAND THE SAFETY DATA SHEET (SDS) FOR THIS PRODUCT AND SPECIFIC INFORMATION PRINTED ON THE PRODUCT CONTAINER.</p>

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