

Stainless Steel MIG•TIG Wire/Rod

GM347 / GT347

AWS A5.9 ER347
JIS Z 3321 YS347
ISO 14343-A-G 19 9 Nb
14343-A-W 19 9 Nb

Product Features:

- Austenite structure weld metal contains adequate ferrite to get low crack sensitivity.
- Weld metal contains Nb element to get good inter-granular corrosion resistance.
- Good high temperature creep strength, acid and heat resistance.

Applications:

- SUS321 to 304L, 309, 309S
- SUS347, 348 to 304L, 309
- SUS310S, 316, 317, 321

Shielding gas:

- Ar+ 1~2% O₂ (MIG)
- 100%Ar (TIG)

Typical chemical composition of wire / rod (wt%)

C	Si	Mn	Ni	Cr	Nb	Fe
0.05	0.43	1.53	9.07	19.11	0.68	Bal.

Typical mechanical properties of all weld metal

Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation %	Impact value (-46°C) J
490	690	40	42

MIG Size (mm) & recommended welding parameters; DC+

Diameter (mm)	0.9/1.0	1.2	1.6
Current range (Amp)	70~200	90~250	200~300

TIG rod size diameter/length; DC-

Diameter (mm)	1.6	2.0	2.4/2.6	3.2
Length (mm)	1000	1000	1000	1000

Note:

Goodweld Corporation
No.99, Huangong Rd. Yongkang Tainan, Taiwan
Phone: 886-6-2331003 Fax: 886-6-2333213
All Right Reserved

GOOD
GOODWELD
www.goodweld.com.tw