

# LNT/LNM 347Si

## Stainless solid wire

### Classification

AWS A5.9-93	: ER347Si
EN 12072-99	: W 19 9 NbSi / G 19 9 NbSi

### General description

**Solid wire for welding Ti or Nb stabilized stainless CrNi-steels**  
**High resistance to intergranular corrosion and oxidizing environments**

### Shielding gases (acc. EN 439)

GTAW	I1	Inert gas Ar (100%)
GMAW	M12	Mixed gas Ar+ >0-5% CO <sub>2</sub> M13 Mixed gas Ar+ >0-3% O <sub>2</sub>

### Approvals

	CTL	DB	LR	TÜV
GTAW	+	+		+
GMAW		+	+	+

### Chemical composition (w%), typical, wire / rod

C	Mn	Si	Cr	Ni	Mo	Nb
0.04	1.3	0.9	19.2	9.9	0.30	0.6

### Mechanical properties, typical, all weld metal

	Process	Shielding gas	Condition	0.2% Proof strength (N/mm <sup>2</sup> )	Tensile strength (N/mm <sup>2</sup> )	Elongation (%)	Impact ISO-V(J)	
							+20°C	-196°C
Typical values	GTAW	I1	AW	400	650	35	80	45
	GMAW	M12	AW	460	650	35	100	

### Materials to be welded

Steel grades	EN 10088-11-2	EN 102 13-4	W.Nr.	ASTM/ACI A240/A312/A351	UNS
Ti-, Nb-stabilized	X6CrNiTi 18-10		1.4541	(TP)321	S32100
				(TP)321H	S32109
	X6 CrNiNb 18-10		1.4550	(TP)347	S34700
Non stabilized		GX5 CrNiNb 19-10	1.4552	(TP)347h	S34709
				CF-8C	J92710
				302	
	X4 CrNi 18-10		1.4301	(TP)304	S30400
	X2 CrNi 19-11		1.4306	(TP)304L	S30403
		GX5 CrNi 19-10	1.4308	CF-8	J92600
			1.4312	(TP)304H	S30409

### Packaging

Process	Unit	Sizes (mm)							
		0.8	1.0	1.2	1.6	2.0	2.4	3.2	
GTAW	2 and 10 kg tube					X	X	X	X
GMAW	15kg spool BS300	X	X	X					

Other sizes and packaging on request

LNT/LNM 347Si: rev. EN 15

**Liability:** All information in this data sheet is based on the best available knowledge, is subject to change without notice and can only be considered as suitable for general guidance **Fumes:** Consult information on Welding Safety Sheet, available upon request

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GMAW / GTAW