

OK Tigrod 347Si

Bare corrosion resisting chromium-nickel rods for welding of austenitic chromium nickel alloys of 18 % Cr-8 % Ni-type. OK Tigrod 347Si has a good general corrosion resistance. The alloy is stabilized with Niobium to improve the resistance against intergranular corrosion of the weld metal. The higher silicon content improves the welding properties, such as wetting. Due to the niobium content this alloy is recommended for use at higher temperatures.

Klasifikace	EN ISO 14343-A : W 19 9 Nb Si SFA/AWS A5.9 : ER347Si Werkstoffnummer : ~1.4551
Schválení	NAKS/HAKC : 1.6 mm - 2.4 mm VdTÜV : 09736

Typ legování	Austenitic (with approx. 8 % ferrite) 19% Cr - 9% Ni - Nb
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Typical Tensile Properties

Condition	Mez skluzu	Mez pevnosti v tahu	Prodloužení
Po svaení	440 MPa (64 ksi)	640 MPa (93 ksi)	35 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Vrbová houževnatost
Po svaení	20 °C (68 °F)	90 J (67 ft-lb)
Po svaení	-60 °C (-76 °F)	75 J (56 ft-lb)

Typického chemického složení svarového kovu v %

C	Mn	Si	S	P	Ni	Cr	Mo	Cu	Nb
0.04	1.5	0.8	0.01	0.02	10	20	0.1	0.1	0.7

Typické složení drátu %

C	Mn	Si	Ni	Cr	Mo	Cu	Nb
0.04	1.7	0.7	9.8	19	0.1	0.10	0.60