BÖHLER SAS 2-IG

TIG rod, high-alloyed, stainless

Classifications

EN ISO 14343-A	EN ISO 14343-B	AWS A5.9
W 19 9 Nb	SS347	ER347

Characteristics and typical fields of application

GTAW rod of type W 19 9 Nb / ER 347 engineered to a very precise analysis to create a weld deposit of high purity, superior hot cracking a corrosion resistance.

CVN toughness down to –196 °C, resistant to intergranular corrosion up to +400 °C.

Base materials

1.4550 X6CrNiNb18-10, 1.4541 X6CrNiTi18-10, 1.4552 G-X5CrNiNb19-11, 1.4301 X5CrNi18-10, 1.4312 GX10CrNi18-8, 1.4546 X5CrNiNb18-10, 1.4311 X2CrNiN18-10, 1.4306 X2CrNi19-11

AISI 347, 321,302, 304, 304L, 304LN; ASTM A296 Gr. CF 8 C, A157 Gr. C9, A320 Gr. B8C or D

Typical analysis of the TIG rods (wt.-%)

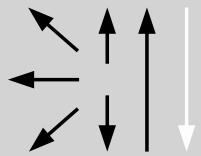
	C	Si	Mn	Cr	Ni	Nb
wt.-%	0.05	0.5	1.8	19.6	9.5	+

Mechanical properties of all-weld metal

Condition	Yield strength $R_{p0,2}$	Tensile strength R_m	Elongation A (L_0=5d_0)	Impact work ISO-V KV J	
	MPa	MPa	%	+20 °C	–196 °C
u	**490** (≥ 350)	**660** (≥ 550)	**35** (≥ 25)	**140**	≥ 32

u untreated, as-welded – shielding gas Argon

Operating data



Polarity:	Shielding gas:	Rod marking:	ø (mm)
DC (–)	100 % Argon	front: W 19 9 Nb back: ER 347	1.6 2.0 2.4 3.0

Preheating and post weld heat treatment is not required by the weld metal deposit

Approvals

TÜV (00142.), GL (4550), LTSS, SEPROZ, CE, NAKS