

INERTFIL 347

Drôt pre zváranie MAG/TIG

Welding rod/wire electrode for TIG/MAG-welding process

Pręty/druty do spawania metodami TIG/MAG

**Standards:**

DIN EN 12072

G 19 9 Nb

DIN 8556

SG X 5 Cr Ni Nb 19 9

AWS/ASME SFA-5.9

ER 347

Comparable No. of Materials:

1.4551

SK Vlastnosti a použitie:

Austenitic welding rod with stabilizers (Nb) for welding unstabilized and stabilized corrosion resistant Cr-Ni steels. Resistant to intergranular corrosion up to 400 °C. In air and oxidizing combustion gases non-scaling up to 800 °C.

GB Applications and properties:

Stabilized austenitic stainless welding rod or wire electrode for TIG/MAG-welding of unstabilized and stabilized corrosion resisting Cr-Ni-steels. Resistant to intergranular corrosion up to 400 °C. In air and oxidizing combustion gases non-scaling up to 800 °C.

POL Zastosowania i właściwości:

Pręt do spawania lub drutu ze stabilizowanej austenitycznej stali nierdzewnej do spawania stabilizowanych lub niestabilizowanych stali nierdzewnych Cr-Ni metodą TIG/MAG. Stopiwo jest odporne na korozję międzykrystaliczną do 400°C. W powietrzu i oksydujących gazach spalinowych stopiwo jest odporne na tworzenie zgorzeliny aż do 800°C.

Materials for instance:

Joint welding of alloy steels							
No. of Materials	EN-Designation		No. of Materials		EN-Designation		
1.4301	X4CrNi18-10			1.4541	X6CrNiTi18-10		

Approvals: TÜV, DB**Rod and wire analysis correspond to all-weld metal analysis (typical values in %)**

C	Si	Mn	Cr	Ni	Nb	P	S
0,06	0,45	1,60	19,50	10,00	0,80	≤0,030	≤0,030

Mechanical properties of all-weld metal (single values are typical values):

Heat treatment	0,2 % Proof stress [N/mm ²]	Tensile strength [N/mm ²]	Elongation A ₅ [%]	Impact energy ISO-V [J]	
				+20 °C	-40 °C
AW	≥400	≥550	≥30	≥47	≥47

AW = as-welded

Analysis and mechanical properties apply to the use of shielding gas:

DIN EN 439 - I1 in TIG – welding

DIN EN 439 - M13 in MAG – welding

Shielding gas acc. to DIN EN 439:

Welding rod for TIG-welding:

I1 (ARCAL 1)

Wire electrode for MAG -welding:

M12 (ARCAL 12), M13 (INARC S 3)

Consumption:

TIG = approx. 10 l/min, MAG = approx. 15 l/min

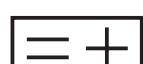
Form of delivery:

Welding rods						
Dia. [mm]	1,0	1,6	2,0	2,4	3,2	4,0
Length [mm]				1000		
Approx. Weight of packet [kgs]				10		

Wire electrodes				
Dia [mm]	0,8	1,0	1,2	1,6
Wire cage reel K300 [kgs]			15	

Further forms of delivery on request.**Type of current/Polarity/Welding positions:**

TIG



MAG

