

# AK ER347L

**Description:** A stainless steel gas shield designed for all position welding, offers better corrosion resistance than Type 308 wires, used to weld 347 and 321 stainless steel. Niobium (Nb) is used as the stabilized element to prevent intergranular corrosion.

**Application:** Used to weld important anti- corrosion steel which contains Nb or nickel chrome alloys which Ti as the stabilized element.

## Typical Chemical Composition(%):

|               | C     | Si   | Mn      | S     | P     | Ni       | Mo   | Cr        | Cu   |
|---------------|-------|------|---------|-------|-------|----------|------|-----------|------|
| Requirement   | 0.03  | 0.65 | 1.0-2.5 | 0.02  | 0.025 | 9.0-11.0 | 0.75 | 19.0-21.5 | 0.75 |
| Actual Result | 0.019 | 0.52 | 1.73    | 0.005 | 0.019 | 9.63     | 0.1  | 19.86     | 0.03 |

## Typical Mechanical Properties:

|               | Tensile strength (MPa) | Yield Stress ( MPa) | Elongation (%) | Impact Values (J) |
|---------------|------------------------|---------------------|----------------|-------------------|
| Requirement   | ≥ 520                  |                     | ≥ 30           | ——                |
| Actual Result | 594                    |                     | 42             | 75J(-60°C)        |