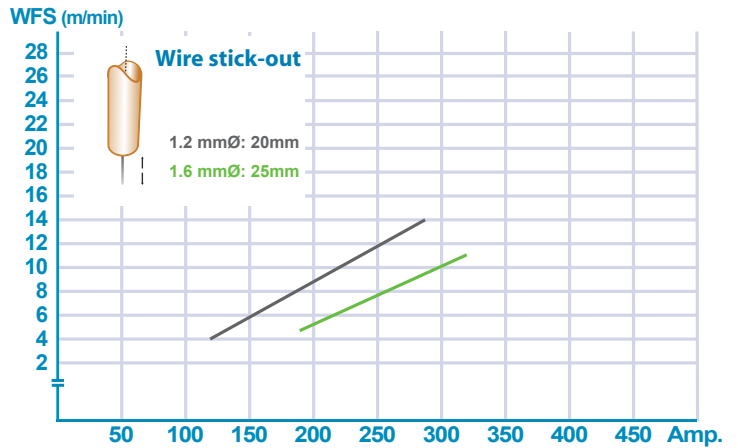
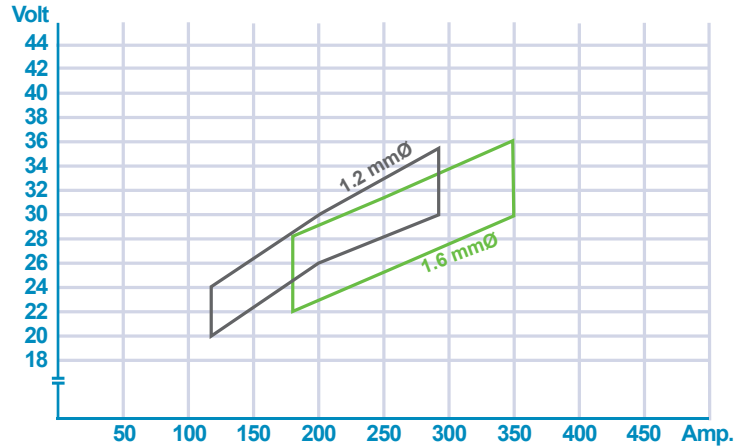


80%Ar - 20%CO₂ / 100%CO₂
 EN ISO 17633-A T 19 9 Nb P C/M 2
 AWS A5.22 E347T1-1/-4
 EN 1.4551

Description and Application

PREMIARC™ DW-347H is for welding titanium or niobium stabilized stainless steel such as 18%Cr-8%Ni-Ti or 18%Cr-8%Ni-Nb stainless steels. Due to the high niobium content in the weld metal, it is possible to prevent Cr-carbide precipitation which leads to intergranular corrosion.

Recommended Parameter Range, for flat position*



Typical Chemical Analysis (wt. %)*

| C | Si | Mn | P | S | Ni | Cr | Mo | N | Nb | FS | FN | FNW |
|------|------|------|-------|-------|------|------|----|---|-----|-----|-----|-----|
| 0.03 | 0.60 | 1.30 | 0.018 | 0.004 | 10.4 | 18.7 | - | - | 0.6 | 6.7 | 7.3 | 6.3 |

Typical Mechanical Properties*

| | R _c (MPa) | R _m (MPa) | A ₅ (%) | CV (J) 0°C |
|-----------|----------------------|----------------------|--------------------|------------|
| Guarantee | min.350 | min.550 | min.30 | 83 |

* The above values and parameters are for all weld metal produced using Ar+CO₂ shielding gas

Welding Positions



Approvals

| LR | DNV | BV | GL | ABS | R.M.R.S | Others |
|----|-----|----|----|-----|---------|--------|
| - | - | - | - | - | - | TÜV |