



Unibraze 347

CLASSIFICATIONS: AWS A5.9/ASME SFA 5.9 Class ER347 UNS S34780

DESCRIPTION: Unibraze 347 is a niobium stabilized stainless steel welding wire used to weld Types 321 and 347. The addition of niobium reduces the possibility of chromium carbide precipitation and inter-granular corrosion.

TYPICAL CHEMISTRY:

C-	Cr	Ni	Mo	Mn	Si	P	S	Cu	Nb + Ta	FN (WRC)
.08 max	19.0-21.5	9.0-11.0	.75 max	1.0-2.0	.30-.65	.03 max	.03 max	.75 max	10xC-1.0	10

TYPICAL MECHANICAL PROPERTIES:

Tensile Strength	86,500 psi (600 MPa)
Yield Strength	57,000 psi (390 MPa)
Elongation	35%

TYPICAL WELDING PARAMETERS:

	Shielding Gas	Gas Flow	Diameter	Voltage	Amperage
MIG	98/99% Ar +2/1% O 97%Ar + 3% CO ₂	30 to 50 CFH	.035" (.9mm)	26-29	160 /210
			.045" (1.14mm)	28-32	180/250
			.062" (1.6mm)	29-33	200/280
TIG	100% Ar		1/16" (1.6mm)	14-18	90/130
			3/32" (2.4mm)	15-20	120/175
			1/8" (3.2mm)	15-20	150/220
SUBARC	Suitable Flux		3/32" (2.4mm)	28-33	275/350
			1/8" (3.2mm)	29-32	350/450

Notice: The results reported are based upon testing of the product under controlled laboratory conditions in accordance with American Welding Society Standards. Actual use of the product may produce different results due to varying conditions. An example of such conditions would be electrode size, plate chemistry, environment, weldment design, fabrication methods, welding procedure and service requirements. Thus the results are not guarantees for use in the field. The manufacturer disclaims any warranty of merchantability or fitness for any particular purpose with respect to its products.