# MIG 20/10MNB

*Old reference*: MIG 347

## Classification

ISO 14343-A : G 19 9 Nb AWS A5.9 : ER347

## Description & Applications

Solid wire for GMAW for joining of stabilised stainless steels (347, 321…), no stabilised low carbon content stainless steels (304L…). Good inter-granular corrosion resistance.

## Typical Chemical Composition ( % )

| C | Si | Mn | Cr | Ni | Mo | Cu | Nb | P | S | Fe |
|---|---|---|---|---|---|---|---|---|---|---|
| 0.03 | <0.65 | 1.5 | 19.5 | 9.8 | 0.2 | 0.1 | 0.5 | <0.02 | <0.01 | Rem. |

## All Weld Metal Mechanical Properties

| $R_{p0.2}$ ( MPa ) | $R_m$ ( MPa ) | $A_5$ ( % ) | KV ( J ) |
|---|---|---|---|
| 460 | 630 | 33 | +20°C 110 |
| | | | -196°C 30 |

## Welding Current & Instructions

| Welding mode | Wire Ø (mm) | Welding parameters | | Shielding Gas |
|---|---|---|---|---|
| | | Pulsed arc (A) | (V) | |
| MIG<br>= + | 0.8<br>1.0<br>1.2<br>1.6 | 100-150<br>120-200<br>140-220<br>180-260 | 22-27<br>24-28<br>24-28<br>24-30 | Ar + 2%$CO_2$<br>Ar + 1%$O_2$<br>18-20 l/min |

Ind.10

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