

DIF-FILL 147

STAINLESS STEEL FILLER WIRE ER 347
FOR TIG , MIG , MAG WELDING

Dif – Fill 147 is a Columbium stabilized solid bare filler wire which typically produces weld metal containing 20 % Cr, 10 % Ni, and Cb (Nb). Presence of Cb and Ta reduces the possibility of intergranular corrosion. Weld metal also provides high temperature strength effectively . Use DC (-) with argon shielding produces excellent quality weld metal.

Applications:

Welding of AISI 304, 304 L, 308, 308 L , 321 and 347 grades.
Welding clad side of above grades. Cladding of carbon and low alloy steels. Suitable for chemical, textile, food, refineries and aircraft industries.

Specification:

AWS / SFA 5.9 : ER 347

Alloy Basis: (%)

C	Si	Mn	Cr	Ni	Mo	Cu	Nb	Fe
0.055max	0.3- 0.65	1.0 – 2.5	19.5- 21	9 - 11	0.5 max	0.5 max	1.0max	BAL

Properties:

Applicable Gas : Welding Grade Argon
Argon + 2.5 % Co₂
Tensile strength : 560 N /mm²
Elongation : 32 %

Packing Standards:

Size (dia mm) - 1.6 mm, 2.0mm, 2.5mm, 3.15mm, 4.00mm
Length - 500 mm and 1000 mm
Packing - 5 kg per packet, 20 kg per case
Spool - MIG welding 0.8 mm,1.2 mm,1.6 mm,-12.5 kg per spool.

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