certilas® THE FILLER METAL SPECIALIST

CEWELD 347H Tig

TYPE	Solid Niobium stabilized stainless steel welding wire
APPLICATIONS	For welding stainless austenitic steels that are exposed to working temperatures up to 400°C.
PROPERTIES	The weld deposit is scale-resistant up to approx. 800°C in normal atmosphere and oxidizing gases. The weld deposit is capable of taking a high polish.Structure: Austenite with delta ferrite UNS 34780

CLASSIFICATION

AWS	A 5.9: ER347
EN ISO	14343-A: W 19 9 Nb
F-nr	6
FM	5
W.Nr.	~ 1.4551

SUITABLE FOR

ISO 15608: 8.1 / TüV Groupe 29 (+22+21) / E347, 19 9 Nb, 1.4551
1.4541, 1.4550, 1.4552 1.4319, 1.4306, 1.4306, 1.4301, 1.4303, 1.4308, 1.4310, 1.4312, *(1.4000, 1.4001, 1.4002, 1.4003, 1.4006)*
X 6 NiTi 18 10, X 6CrNiNb 18 10, G-X 5CrNiNb 18 9, X 5CrNi 18 7, X 2CrNi 19 11, G-X 2CrNi 18 9, X 5CrNi 18 10,
X 5CrNi 18 12 G-X, 6CrNi 18 9, X 12CrNi 17 7, G-X 10CrNi 18 8
AISI: 321, 347

APPROVALS: CE

WELDING POSITIONS

TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

C	Si	Mn	P	S	Cr	Ni	Nb
0.04	0.5	1.9	0.01	0.01	20	10	0.5

ALL WELD MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ MPa	Rm MPa	A5 (%)	Impact Energy (J) ISO-V RT
As Welded /1h	390	590	31	80

REDRYING TEMPERATURE	Not required
GAS ACCORDING EN 14175	I1

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347H TIG 1,6 X 1000MM

Type	KG/unit	EANCode
Tube	5	8720663413260