certilas® THE FILLER METAL SPECIALIST

CEWELD 347Si Tig

TYPE	Filler metal for welding stabilized stainless austenitic steels that are exposed to working temperatures up to 400°C
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

CLASSIFICATION

AWS	A 5.9: ER347Si
EN ISO	14343-A: W 19 9 Nb Si
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

TÜV (TÜV (12392.00)) CE

WELDING POSITIONS

TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

C	Si	Mn	P	S	Cr	Ni
0.04	0.7	2	0.007	0.01	20	10

ALL WELD MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ MPa	Rm MPa	A5 (%)	Impact Energy (J) ISO-V RT	Impact Energy (J) ISO-V -196°C
As Welded /	450	610	35	90	45

REDRYING TEMPERATURE	Not required
GAS ACCORDING EN 14175	I1

CEWELD 347Si Tig

certilas® THE FILLER METAL SPECIALIST

347SI TIG 1,0 X 1000MM

Type	KG/unit	EANCode
Tube	5	8720663412843

347SI TIG 1,2 X 1000MM

Type	KG/unit	EANCode
Tube	5	8720663412850

347SI TIG 1,6 X 1000MM

Type	KG/unit	EANCode
Tube	5	8720663412881

347SI TIG 2,0 X 1000MM

Type	KG/unit	EANCode
Tube	5	8720663412898

347SI TIG 2,4 X 1000MM

Type	KG/unit	EANCode
Tube	5	8720663412904

347SI TIG 3,2 X 1000MM

Type	KG/unit	EANCode
Tube	5	8720663412911