



# CEWELD SA 347 strip

|                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                  |                       |                    |        |     |    |    |     |
|---------------------------------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------------|--------------------|--------|-----|----|----|-----|
| TYPE                                              | Solid stainless steel welding strip                                                                                                                                                                                                                                                                                                                                                                              |                       |                    |        |     |    |    |     |
| APPLICATIONS                                      | Overlay welding of surfaces to reach high intergranular corrosion resistance                                                                                                                                                                                                                                                                                                                                     |                       |                    |        |     |    |    |     |
| PROPERTIES                                        | SA 347 strip is trip s stainless steel strip for cladding overlay applications. Latest generation clean melting quality guarantees optimum metallurgical quality and attractive weld appeal. Combined with our high basic electro slag flux FL 830 ESHC excellent results are obtained in both deposition rate as minimum dilution rate due to the higher slag temperature compare to other electro slag fluxes. |                       |                    |        |     |    |    |     |
| CLASSIFICATION                                    | AWS                                                                                                                                                                                                                                                                                                                                                                                                              | A 5.9: EQ347          |                    |        |     |    |    |     |
|                                                   | EN ISO                                                                                                                                                                                                                                                                                                                                                                                                           | 14343-A: B 19 9 Nb    |                    |        |     |    |    |     |
|                                                   | W.Nr.                                                                                                                                                                                                                                                                                                                                                                                                            | 1.4551                |                    |        |     |    |    |     |
| SUITABLE FOR                                      | <b>ISO 15608: 8.1 / TÜV Groupe 29 (+22+21) / E347, 19 9 Nb, 1.4551</b><br>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)<br>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,<br>X 5CrNi 18 12 G-X, 6CrNi 18 9, X 12CrNi 17 7, G-X 10CrNi 18 8<br>AISI: 321, 347   |                       |                    |        |     |    |    |     |
| APPROVALS                                         | CE                                                                                                                                                                                                                                                                                                                                                                                                               |                       |                    |        |     |    |    |     |
| WELDING POSITIONS                                 |                                                                                                                                                                                                                                                                                                                                |                       |                    |        |     |    |    |     |
| TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%) | C                                                                                                                                                                                                                                                                                                                                                                                                                | Si                    | Mn                 | P      | S   | Cr | Ni | Nb  |
|                                                   | 0.06                                                                                                                                                                                                                                                                                                                                                                                                             | 0.55                  | 2                  | 0.2    | 0.1 | 20 | 10 | 0.5 |
| ALL WELD MECHANICAL PROPERTIES                    | Heat Treatment                                                                                                                                                                                                                                                                                                                                                                                                   | R <sub>P0,2</sub> MPa | R <sub>m</sub> MPa | A5 (%) |     |    |    |     |
|                                                   | As Welded /                                                                                                                                                                                                                                                                                                                                                                                                      | 360                   | 570                |        |     |    |    |     |
| REDRYING TEMPERATURE                              | Not required                                                                                                                                                                                                                                                                                                                                                                                                     |                       |                    |        |     |    |    |     |
| GAS ACCORDING EN 14175                            |                                                                                                                                                                                                                                                                                                                                                                                                                  |                       |                    |        |     |    |    |     |