CEWELD AA 347H

certilas® THE FILLER METAL SPECIALIST

TYPE	Rutile fluxcored wire for welding stabilized stainless steel
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. This fluxcored wire offers higher productivity, higher deposition rate and improved wetting properties due to slag support especially in positional welding. Excellent weldabillity and suitable for use with ceramic backing strips. Excellent weld metal quality and X-ray soundness.

CLASSIFICATION

AWS	A 5.22: E347T1-1
AWS	A 5.22: E347T1-4
EN ISO	17633-A: T 19 9 Nb P M21 1
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: No Approvals Found

WELDING POSITIONS

TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	P	Cr	Ni	Nb+Ta	S
0.02	0.5	1.3	0.02	19.5	10.5	0.4	0.02

ALL WELD MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ MPa	Rm MPa	A5 (%)	Impact Energy (J) ISO-V RT
As Welded /	440	620	37	85

REDRYING TEMPERATURE: 140°C / 24 hr

GAS ACCORDING EN 14175: M21

CEWELD AA 347H

AA 347H 1,2MM

Type	KG/unit	EANCode
BS-300	15	8720663413604