



# CEWELD AA 347H

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 weldability and suitable for use with ceramic backing strips. Excellent weld metal quality and X-ray soundness.																			
CLASSIFICATION	AWS	A 5.22: E347T1-4 A 5.22: E347HT1-1/4																		
	EN ISO	17633-A: T 19 9 Nb P M21 1																		
	DIN	1.4551																		
	F-nr	6																		
	FM	5																		
SUITABLE FOR	<b>ISO 15608: 8.1 (no Mo) 1.4551</b> 1.4303, 1.4306, 1.4308, 1.4310, 1.4311, 1.4312, 1.4319, 1.4541, 1.4546, 1.4550, 1.4552, 1.4878 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: 347, 321,302, 304, 304L, 304LN UNS S30400, S30403, S30453, S32100, S34700																			
APPROVALS	No Approvals Found																			
WELDING POSITIONS																				
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	<table border="1"> <thead> <tr> <th>C</th> <th>Si</th> <th>Mn</th> <th>P</th> <th>Cr</th> <th>Ni</th> <th>Nb+Ta</th> <th>S</th> <th>Nb</th> </tr> </thead> <tbody> <tr> <td>0.06</td> <td>0.9</td> <td>1.4</td> <td>0.02</td> <td>19.5</td> <td>10.5</td> <td>0.4</td> <td>0.02</td> <td>0.7</td> </tr> </tbody> </table>	C	Si	Mn	P	Cr	Ni	Nb+Ta	S	Nb	0.06	0.9	1.4	0.02	19.5	10.5	0.4	0.02	0.7	
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As Welded /	440	620	37	85																
REDRYING TEMPERATURE	140°C / 24 hr																			
GAS ACCORDING EN 14175	M21																			



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AA 347H 1,2MM

Type	KG/unit	EANCode
BS-300	15	8720663413604