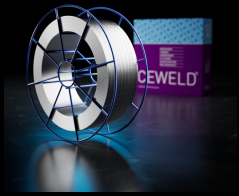




CEWELD AA 347H

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	<table border="0"> <tr> <td>AWS</td> <td>A 5.22: E347T1-1</td> </tr> <tr> <td>AWS</td> <td>A 5.22: E347T1-4</td> </tr> <tr> <td>EN ISO</td> <td>17633-A: T 19 9 Nb P M21 1</td> </tr> <tr> <td>F-nr</td> <td>6</td> </tr> <tr> <td>FM</td> <td>5</td> </tr> <tr> <td>W.Nr.</td> <td>1.4551</td> </tr> </table>	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				
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SUITABLE FOR	<p>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</p>																
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> </tr> </thead> <tbody> <tr> <td>0.02</td> <td>0.5</td> <td>1.3</td> <td>0.02</td> <td>19.5</td> <td>10.5</td> <td>0.4</td> <td>0.02</td> </tr> </tbody> </table>	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
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ALL WELD MECHANICAL PROPERTIES	<table border="1"> <thead> <tr> <th>Heat Treatment</th> <th>R_{p0,2} MPa</th> <th>R_m MPa</th> <th>A₅ (%)</th> <th>Impact Energy (J) ISO-V RT</th> </tr> </thead> <tbody> <tr> <td>As Welded /</td> <td>440</td> <td>620</td> <td>37</td> <td>85</td> </tr> </tbody> </table>	Heat Treatment	R _{p0,2} MPa	R _m MPa	A ₅ (%)	Impact Energy (J) ISO-V RT	As Welded /	440	620	37	85						
Heat Treatment	R _{p0,2} MPa	R _m MPa	A ₅ (%)	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