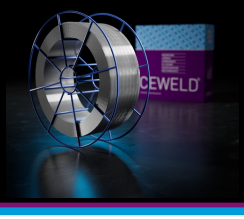

CEWELD 347Si

certilas® THE FILLER METAL SPECIALIST

TYPE

Solid Niobium stabilized stainless steel welding wire

APPLICATIONS

For welding stainless austenitic steels that are exposed to working temperatures up to 400°C.

PROPERTIES

CEWELD 347Si is made for welding austenitic stainless steels stabilized with Nb or Ti, like 347 and 321, which contain 18% chromium and 10% nickel. It can also be used for non-stabilized types such as 304 and 304L. The weld deposit is scale-resistant up to approx. 800°C in normal atmosphere and oxidizing gases Thanks to its higher silicon content, it provides improved arc stability and smoother weld metal flow, leading to a cleaner and more polished weld appearance, especially in dip transfer welding

CLASSIFICATION

AWS	A 5.9: ER347Si
EN ISO	14343-A: G 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, 1.4878,
(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 (12393.00) CE

WELDING POSITIONS

TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

C	Si	Mn	Cr	Ni
0.04	0.7	1.9	19.5	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 /	420	590	35	80	45

REDRYING TEMPERATURE

Not required

GAS ACCORDING EN 14175

M13, M12