



CEWELD 347H Tig

| 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 | 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 UNS 34780 | | | | | | | | | | | | | | | | |
| CLASSIFICATION | <table border="0"> <tr> <td>AWS</td> <td>A 5.9: ER347</td> </tr> <tr> <td>EN ISO</td> <td>14343-A: W 19 9 Nb</td> </tr> <tr> <td>W.Nr.</td> <td>~ 1.4551</td> </tr> <tr> <td>F-nr</td> <td>6</td> </tr> <tr> <td>FM</td> <td>5</td> </tr> </table> | AWS | A 5.9: ER347 | EN ISO | 14343-A: W 19 9 Nb | W.Nr. | ~ 1.4551 | F-nr | 6 | FM | 5 | | | | | | |
| AWS | A 5.9: ER347 | | | | | | | | | | | | | | | | |
| EN ISO | 14343-A: W 19 9 Nb | | | | | | | | | | | | | | | | |
| W.Nr. | ~ 1.4551 | | | | | | | | | | | | | | | | |
| F-nr | 6 | | | | | | | | | | | | | | | | |
| FM | 5 | | | | | | | | | | | | | | | | |
| 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 | CE | | | | | | | | | | | | | | | | |
| WELDING POSITIONS | | | | | | | | | | | | | | | | | |
| TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%) | <table border="1"> <thead> <tr> <th>C</th> <th>Si</th> <th>Mn</th> <th>P</th> <th>S</th> <th>Cr</th> <th>Ni</th> <th>Nb</th> </tr> </thead> <tbody> <tr> <td>0.04</td> <td>0.5</td> <td>1.9</td> <td>0.01</td> <td>0.01</td> <td>20</td> <td>10</td> <td>0.5</td> </tr> </tbody> </table> | C | Si | Mn | P | S | Cr | Ni | Nb | 0.04 | 0.5 | 1.9 | 0.01 | 0.01 | 20 | 10 | 0.5 |
| C | Si | Mn | P | S | Cr | Ni | Nb | | | | | | | | | | |
| 0.04 | 0.5 | 1.9 | 0.01 | 0.01 | 20 | 10 | 0.5 | | | | | | | | | | |
| MECHANICAL PROPERTIES | <table border="1"> <thead> <tr> <th rowspan="2">Heat Treatment</th> <th rowspan="2">R_{P0.2} (MPa)</th> <th rowspan="2">R_m (MPa)</th> <th rowspan="2">A₅ (%)</th> <th colspan="2">Impact Energy (J) ISO-V</th> <th rowspan="2">Hardness</th> </tr> <tr> <th colspan="2">RT</th> </tr> </thead> <tbody> <tr> <td>As Welded</td> <td>390</td> <td>590</td> <td>31</td> <td colspan="2">80</td> <td>HRc</td> </tr> </tbody> </table> | Heat Treatment | R _{P0.2} (MPa) | R _m (MPa) | A ₅ (%) | Impact Energy (J) ISO-V | | Hardness | RT | | As Welded | 390 | 590 | 31 | 80 | | HRc |
| Heat Treatment | R _{P0.2} (MPa) | | | | | R _m (MPa) | A ₅ (%) | | Impact Energy (J) ISO-V | | Hardness | | | | | | |
| | | RT | | | | | | | | | | | | | | | |
| As Welded | 390 | 590 | 31 | 80 | | HRc | | | | | | | | | | | |
| REDRYING | Not required | | | | | | | | | | | | | | | | |
| GAS ACC. EN ISO 14175 | I1 | | | | | | | | | | | | | | | | |



CEWELD 347H Tig

347H TIG 1,6 X 1000MM

| Packaging | KG/unit | EanCode |
|-----------|---------|---------------|
| Tube | 5 | 8720663413260 |