



# CEWELD AA 347 Tig

**TYPE** Flux cored stainless steel welding wire for Tig welding

**APPLICATIONS** Boilers, shipbuilding, machinery, offshore application, foundries, chemical industry, root pass welding when backing gas is not available or preferred.

**PROPERTIES** These are all rutile flux cored TIG filler rods for root pass welding of stainless steel pipe without the need for a reverse side back purge (internal shielding gas). As they produce a slag, they are not recommended for multi-pass welding.

**CLASSIFICATION**

AWS	A 5.22: R347T1-5
W.Nr.	1.4550
F-nr	6
FM	5

**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**

**WELDING POSITIONS**



**TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)**

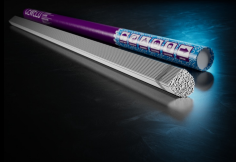
C	Si	Mn	P	S	Cr	Ni	Nb+Ta
0.02	0.8	1.6	0.025	0.025	19.5	10.5	0.4

**MECHANICAL PROPERTIES**

Heat Treatment	R <sub>P0,2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	Impact Energy (J) ISO-V		Hardness
				RT		
As Welded	460	630	48	130		HRC

**REDRYING** Not required

**GAS ACC. EN ISO 14175** 11



# CEWELD AA 347 Tig

AA 347 TIG 2,2 X 1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663413611