CEWELD AA 347H

certilas® THE FILLER METAL SPECIALIST

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.

PROPRIÉTÉS

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 weldabillity 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

CONVIENT POUR

ISO 15608: 8.1 (no Mo) 1.4551
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

AGRÉMENTS

POSITIONS DE SOUDAGE

ANALYSE CHIMIQUE TYPIQUE DU MÉTAL DE SOUDURE (%)

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

PROPRIÉTÉS MÉCANIQUES

Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Impact Energy (J) ISO-V	Hardness
				RT	
As Welded	440	620	37	85	HRc

ETUVAGE

140°C / 24 hr

GAS ACC. EN ISO 14175

M21

CEWELD AA 347H

AA 347H 1,2MM

Packaging	KG/unit	EanCode
BS-300	15	8720663413604