



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

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

SUITABLE FOR **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

APPROVALS

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

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

MECHANICAL PROPERTIES

Heat Treatment	R _{p0.2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V	Hardness
				RT	
As Welded	440	620	37	85	HRc

REDRYING 140°C / 24 hr

GAS ACC. EN ISO 14175 M21



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AA 347H 1,2MM

Packaging	KG/unit	EanCode
BS-300	15	8720663413604