



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.

PROPRIÉTÉS 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

CONVIENT POUR **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

AGRÉMENTS

POSITIONS DE SOUDAGE



ANALYSE CHIMIQUE TYPIQUE DU MÉTAL DE SOUDURE (%)	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

PROPRIÉTÉS MÉCANIQUES	Heat Treatment	R _{P0.2} (MPa)	R _m (MPa)	A5 (%)	Impact Energy (J) ISO-V	Hardness
					RT	
	As Welded	460	630	48	130	HRc

ETUVAGE Not required

GAS ACC. EN ISO 14175 I1



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AA 347 TIG 2,2 X 1000MM	Packaging	KG/unit	EanCode
	Tube	5	8720663413611