



CEWELD 347Si Tig

TYPE Filler metal for welding stabilized stainless austenitic steels that are exposed to working temperatures up to 400°C

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

CLASSIFICATION

| | |
|--------|-----------------------|
| AWS | A 5.9: ER347Si |
| EN ISO | 14343-A: W 19 9 Nb Si |
| W.Nr. | 1.4551 |
| 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 TÜV: TÜV (12392.00), CE

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

| C | Si | Mn | P | S | Cr | Ni |
|------|-----|----|-------|------|----|----|
| 0.04 | 0.7 | 2 | 0.007 | 0.01 | 20 | 10 |

MECHANICAL PROPERTIES

| Heat Treatment | R _{p0,2} (MPa) | R _m (MPa) | A ₅ (%) | Impact Energy (J) ISO-V | | Hardness |
|----------------|-------------------------|----------------------|--------------------|-------------------------|--------|----------|
| | | | | RT | -196°C | |
| As Welded | 450 | 610 | 35 | 90 | 45 | HRc |

REDRYING Not required

GAS ACC. EN ISO 14175 I1



CEWELD 347Si Tig

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|------------------------|-----------|---------|---------------|
| 347SI TIG 1,0 X 1000MM | Packaging | KG/unit | EanCode |
| | Tube | 5 | 8720663412843 |
| 347SI TIG 1,2 X 1000MM | Packaging | KG/unit | EanCode |
| | Tube | 5 | 8720663412850 |
| 347SI TIG 1,6 X 1000MM | Packaging | KG/unit | EanCode |
| | Tube | 5 | 8720663412881 |
| 347SI TIG 2,0 X 1000MM | Packaging | KG/unit | EanCode |
| | Tube | 5 | 8720663412898 |
| 347SI TIG 2,4 X 1000MM | Packaging | KG/unit | EanCode |
| | Tube | 5 | 8720663412904 |
| 347SI TIG 3,2 X 1000MM | Packaging | KG/unit | EanCode |
| | Tube | 5 | 8720663412911 |