



# CEWELD 347Si

**TYPE** Solid Niobium stabilized stainless steel welding wire

**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: G 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: 12393.00, CE

**WELDING POSITIONS**



**TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)**

C	Si	Mn	Cr	Ni
0.04	0.7	1.9	19.5	10

**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	-196°C	
As Welded	420	590	35	80	45	HRC

**REDRYING** Not required

**GAS ACC. EN ISO 14175** M13, M12