



# CEWELD AA 347 Tig

|                                                    |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              |                         |                      |                    |                         |      |          |       |
|----------------------------------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------------------|----------------------|--------------------|-------------------------|------|----------|-------|
| TYPE                                               | Flux cored stainless steel welding wire for Tig welding                                                                                                                                                                                                                                                                                                                                                                                                                                                                      |                         |                      |                    |                         |      |          |       |
| ANWENDUNGEN                                        | Boilers, shipbuilding, machinery, offshore application, foundries, chemical industry, root pass welding when backing gas is not available or preferred.                                                                                                                                                                                                                                                                                                                                                                      |                         |                      |                    |                         |      |          |       |
| EIGENSCHAFTEN                                      | 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.                                                                                                                                                                                                                                                                              |                         |                      |                    |                         |      |          |       |
| KLASSIFIKATION                                     | AWS                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          | A 5.22: R347T1-5        |                      |                    |                         |      |          |       |
|                                                    | W.Nr.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        | 1.4550                  |                      |                    |                         |      |          |       |
|                                                    | F-nr                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         | 6                       |                      |                    |                         |      |          |       |
|                                                    | FM                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           | 5                       |                      |                    |                         |      |          |       |
| GEEIGNET FÜR                                       | ISO 15608: 8.1 / TÜV Groupe 29 (+22+21) / E347, 19 9 Nb, 1.4551<br>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)<br>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,<br>X 5CrNi 18 12 G-X, 6CrNi 18 9, X 12CrNi 17 7, G-X 10CrNi 18 8<br>AISI: 321, 347                                                                                                              |                         |                      |                    |                         |      |          |       |
| ZULASSUNGEN                                        |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              |                         |                      |                    |                         |      |          |       |
| SCHWEISSPOSITIONEN                                 | <div>     </div> |                         |                      |                    |                         |      |          |       |
| TYPISCHE CHEMISCHE ANALYSE DES SCHWEISSMETALLS (%) | 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   |
| MECHANISCHE GÜTEWERTE                              | Heat Treatment                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               | R <sub>P0,2</sub> (MPa) | R <sub>m</sub> (MPa) | A <sub>5</sub> (%) | Impact Energy (J) ISO-V |      | Hardness |       |
|                                                    |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              |                         |                      |                    | RT                      |      |          |       |
|                                                    | As Welded                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    | 460                     | 630                  | 48                 | 130                     |      | HRc      |       |
| RÜCKTROCKNUNG                                      | Not required                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 |                         |                      |                    |                         |      |          |       |
| GAS ACC. EN ISO 14175                              | I1                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |                         |                      |                    |                         |      |          |       |



# CEWELD AA 347 Tig

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