



# CEWELD 327 Tig

|                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                   |                         |                      |                    |                         |  |
|---------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------------------|----------------------|--------------------|-------------------------|--|
| TYPE                                              | Solid stainless steel welding wire for high temperature applications                                                                                                                                                                                                                                                                                                                                                              |                         |                      |                    |                         |  |
| TOEPASSINGEN                                      | Cap layers for joining refractory Cr-Al-Si steels, cladding corrosion resistant overlays, cladding heat resistant overlays up to 1100°C, cladding components in a sulphurous environment.                                                                                                                                                                                                                                         |                         |                      |                    |                         |  |
| EIGENSCHAPPEN                                     | High chromium-alloyed welding wire (ER 327-ER 329) based on a 25% Chromium and 4% Nickel deposit for cladding and joining components against corrosion, high-heat and wear resistance<br>Excellent weld metal quality and X-ray soundness, stable arc at high currents and good machinable deposit.                                                                                                                               |                         |                      |                    |                         |  |
| CLASSIFICATIE                                     | EN ISO                                                                                                                                                                                                                                                                                                                                                                                                                            | 14343-A: W 25 4         |                      |                    |                         |  |
|                                                   | W.Nr.                                                                                                                                                                                                                                                                                                                                                                                                                             | 1.4820                  |                      |                    |                         |  |
|                                                   | F-nr                                                                                                                                                                                                                                                                                                                                                                                                                              | 6                       |                      |                    |                         |  |
|                                                   | FM                                                                                                                                                                                                                                                                                                                                                                                                                                | 5                       |                      |                    |                         |  |
| GESCHIKT VOOR                                     | 1.4710, 1.4745, 1.4712, 1.4762, 1.4713, 1.4773, 1.4722, 1.4776, 1.4724, 1.4820, 1.4729, 1.4821, 1.4740, 1.4822, 1.4742, 1.4823<br>G-X30CrSi6, G-X40CrSi23 TP433, X10CrSi6 502, X10CrAl24 TP443, X10CrAl7 502, X8Cr30, X10CrSi13, G-X40CrSi29, X10CrAl13 TP405-CA15, G-X12CrSi 26 5, G-X40CrSi13, X20CrNiSi 25 4 TP329, G-X40CrSi17, G-X40CrNi 25 4 TP329, X10CrAl18 430B-TP430, G-X40CrNiSi 27 4 TP329HC<br>AISI 327, ASTM A297HC |                         |                      |                    |                         |  |
| GOEDKEURINGEN                                     |                                                                                                                                                                                                                                                                                                                                                                                                                                   |                         |                      |                    |                         |  |
| LASPOSITIES                                       |                                                                                                                                                                                                                                                                                                                                                                                                                                   |                         |                      |                    |                         |  |
| TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%) | C                                                                                                                                                                                                                                                                                                                                                                                                                                 | Si                      | Mn                   | Cr                 | Ni                      |  |
|                                                   | 0.1                                                                                                                                                                                                                                                                                                                                                                                                                               | 0.6                     | 2                    | 26                 | 5                       |  |
| MECHANISCHE WAARDEN                               | Heat Treatment                                                                                                                                                                                                                                                                                                                                                                                                                    | R <sub>P0,2</sub> (MPa) | R <sub>m</sub> (MPa) | A <sub>5</sub> (%) | Impact Energy (J) ISO-V |  |
|                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                   |                         |                      |                    | -20°C                   |  |
|                                                   | As Welded                                                                                                                                                                                                                                                                                                                                                                                                                         | 450                     | 660                  | 15                 | 55                      |  |
|                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                   |                         |                      |                    | Hardness                |  |
|                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                   |                         |                      |                    | HRc                     |  |
| HERDROGEN                                         | Not required                                                                                                                                                                                                                                                                                                                                                                                                                      |                         |                      |                    |                         |  |
| GAS ACC. EN ISO 14175                             |                                                                                                                                                                                                                                                                                                                                                                                                                                   |                         |                      |                    |                         |  |



## CEWELD 327 Tig

327 TIG 1,6 X 1000MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| Tube      | 5       | 8720663415899 |

327 TIG 3,2 X 1000MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| Tube      | 5       | 8720663415929 |