



CEWELD SA 347 strip

TYPE Solid stainless steel welding strip

ANWENDUNGEN Overlay welding of surfaces to reach high intergranular corrosion resistance

EIGENSCHAFTEN SA 347 strip is trip s stainless steel strip for cladding overlay applications. Latest generation clean melting quality guarantees optimum metallurgical quality and attractive weld appeal. Combined with our high basic electro slag flux FL 830 ESHC excellent results are obtained in both deposition rate as minimum dilution rate due to the higher slag temperature compare to other electro slag fluxes.

KLASSIFIKATION

AWS	A 5.9: EQ347
EN ISO	14343-A: B 19 9 Nb
W.Nr.	1.4551

GEEIGNET FÜR **ISO 15608: 8.1 / TÜV Gruppe 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

ZULASSUNGEN CE

SCHWEISSPOSITIONEN



TYPISCHE CHEMISCHE ANALYSE DES FÜLLMETALLS (%)	C	Si	Mn	P	S	Cr	Ni	Nb
	0.06	0.55	2	0.2	0.1	20	10	0.3

MECHANISCHE GÜTEWERTE	Heat Treatment	R _{P0.2} (MPa)	R _m (MPa)	A ₅ (%)	Hardness
	As Welded	360	570		HRc

RÜCKTROCKNUNG Not required

GAS ACC. EN ISO 14175