



CEWELD 347H Tig

TYPE Filler metal for welding stabilized stainless austenitic steels 18/8 up to 800°C. (Type 19 9 Nb, 347)

APPLICATIONS CEWELD® 347H Tig is designed for welding high-carbon 18/8 steels, especially titanium- and niobium-stabilized steels such as 321H and 347H. Main applications include catalytic crackers (also known as "cat crackers"), cyclones, transfer lines, furnace components, steam lines, superheater manifolds, and various components of gas and steam turbines. The product is widely used in petrochemical plants, the chemical industry, and power generation.

PROPERTIES CEWELD® 347H Tig has a carbon content of 0.04 to 0.08%, which gives the compound increased mechanical and structural strength at high temperatures up to approximately 800 °C. The niobium it contains prevents intergranular corrosion, even under particularly demanding operating conditions. For base materials with a thickness greater than 12 mm, CEWELD® 18.8.2 Tig should be used.

CLASSIFICATION

AWS	A 5.9: ER347
EN ISO	14343-A: W 19 9 Nb
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, 1.4878, (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 CE

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

C	Si	Mn	P	S	Cr	Ni	Mo	Nb	Cu
0.055	0.35	1.5	0.01	0.01	20	10	0.1	0.6	0.07

MECHANICAL PROPERTIES

Heat Treatment	R _{P0,2} (MPa)	Rm (MPa)	A5 (%)	Impact Energy (J) ISO-V		Hardness
				RT	-50°C	
As Welded	450	660	45	100	80	HRc

REDRYING

Not required

GAS ACC. EN ISO 14175

I1



CEWELD 347H Tig

347H TIG 1,6 X 1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663413260