



CEWELD 327 Tig

TYPE	Solid stainless steel welding wire for high temperature applications					
APPLICATIONS	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.					
PROPERTIES	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 Excellent weld metal quality and X-ray soundness, stable arc at high currents and good machinable deposit.					
CLASSIFICATION	EN ISO	14343-A: W 25 4				
	W.Nr.	1.4820				
	F-nr	6				
	FM	5				
SUITABLE FOR	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 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 AISI 327, ASTM A297HC					
APPROVALS						
WELDING POSITIONS						
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	C	Si	Mn	Cr	Ni	
	0.1	0.6	2	26	5	
MECHANICAL PROPERTIES	Heat Treatment	R _{p0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V	
					-20°C	
	As Welded	450	660	15	55	
REDRYING	Not required					
GAS ACC. EN ISO 14175						



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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