CEWELD AA 347 Tig

certilas® THE FILLER METAL SPECIALIST

TYPE

Flux cored stainless steel welding wire for Tig welding

APPLICATIONS

Boilers, shipbuilding, machinery, offshore application, foundries, chemical industry, root pass welding when backing gas is not available or prefered.

PROPRIÉTÉS

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.

CLASSIFICATION

AWS	A 5.22: R347T1-5
W.Nr.	1.4550
F-nr	6
FM	5

CONVIENT POUR

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

AGRÉMENTS

POSITIONS DE SOUDAGE

ANALYSE CHIMIQUE TYPIQUE DU MÉTAL DE SOUDURE (%)

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

PROPRIÉTÉS MÉCANIQUES

Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Impact Energy (J) ISO-V	Hardness
				RT	
As Welded	460	630	48	130	HRc

ETUVAGE

Not required

GAS ACC. EN ISO 14175

I1

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AA 347 TIG 2,2 X 1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663413611