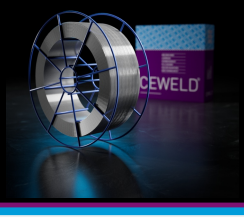

CEWELD 347Si

certilas® THE FILLER METAL SPECIALIST

TYPE

Solid Niobium stabilized stainless steel welding wire

APPLICATIONS

For welding stainless austenitic steels that are exposed to working temperatures up to 400°C.

PROPERTIES

The weld deposit is scale-resistant up to approx. 800°C in normal atmosphere and oxidizing gases. The weld deposit is capable of taking a high polish. Structure: Austenite with delta ferrite

CLASSIFICATION

AWS	A 5.9: ER347Si
EN ISO	14343-A: G 19 9 Nb Si
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, *(1.4000, 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

TÜV: 12393.00, CE

WELDING POSITIONS

TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

C	Si	Mn	Cr	Ni
0.04	0.7	1.9	19.5	10

MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Impact Energy (J) ISO-V		Hardness
				RT	-196°C	
As Welded	420	590	35	80	45	HRc

REDRYING

Not required

GAS ACC. EN ISO 14175

M13, M12