



# CEWELD 327 Tig

<b>TYPE</b>	Solid stainless steel welding wire for high temperature applications	
<b>TOEPASSINGEN</b>	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.	
<b>EIGENSCHAPPEN</b>	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.	
<b>CLASSIFICATIE</b>	EN ISO	14343-A: W 25 4
	W.Nr.	1.4820
	F-nr	6
	FM	5
<b>GESCHIKT VOOR</b>	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	

**GOEDKEURINGEN**

**LASPOSITIES**

**TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)**

C	Si	Mn	Cr	Ni
0.1	0.6	2	26	5

**MECHANISCHE WAARDEN**

Heat Treatment	R <sub>p0,2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	Impact Energy (J) ISO-V	Hardness
				-20°C	
As Welded	450	660	15	55	HRc

**HERDROGEN** Not required

**GAS ACC. EN ISO 14175**



# CEWELD 327 Tig

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