CEWELD AA 347 Tig

certilas® THE FILLER METAL SPECIALIST

TYPE	Flux cored stainless steel welding wire for Tig welding
TOEPASSINGEN	Boilers, shipbuilding, machinery, offshore application, foundries, chemical industry, root pass welding when backing gas is not available or prefered.
EIGENSCHAPPEN	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.

CLASSIFICATIE

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

GESCHIKT VOOR

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

GOEDKEURINGEN

LASPOSITIES

TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

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

MECHANISCHE WAARDEN

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

HERDROGEN 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