



# CEWELD AA 347H

**TYPE** Rutile fluxcored wire for welding stabilized stainless steel

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

**EIGENSCHAFTEN** 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. This fluxcored wire offers higher productivity, higher deposition rate and improved wetting properties due to slag support especially in positional welding. Excellent weldability and suitable for use with ceramic backing strips. Excellent weld metal quality and X-ray soundness.

**KLASSIFIKATION**

AWS	A 5.22: E347T1-4, A 5.22: E347HT1-1/4
EN ISO	17633-A: T 19 9 Nb P M21 1
DIN	1.4551
F-nr	6
FM	5

**GEEIGNET FÜR** **ISO 15608: 8.1 (no Mo) 1.4551**  
 1.4303, 1.4306, 1.4308, 1.4310, 1.4311, 1.4312, 1.4319, 1.4541, 1.4546, 1.4550, 1.4552, 1.4878  
 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: 347, 321,302, 304, 304L, 304LN  
 UNS S30400, S30403, S30453, S32100, S34700

**ZULASSUNGEN**

**SCHWEISSPOSITIONEN**



**TYPISCHE CHEMISCHE ANALYSE DES SCHWEISSMETALLS (%)**

C	Si	Mn	P	Cr	Ni	Nb+Ta	S	Nb
0.06	0.9	1.4	0.02	19.5	10.5	0.4	0.02	0.7

**MECHANISCHE GÜTEWERTE**

Heat Treatment	R <sub>p0,2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	Impact Energy (J) ISO-V		Hardness
				RT		
As Welded	440	620	37	85		HRC

**RÜCKTROCKNUNG** 140°C / 24 hr

**GAS ACC. EN ISO 14175** M21



# CEWELD AA 347H

AA 347H 1,2MM

Packaging	KG/unit	EanCode
BS-300	15	8720663413604