CEWELD 347H

TYPE

Filler metal for welding stabilized stainless austenitic steels 18/8 up to 800°C. (Type 19 9 Nb, 347)

APPLICATIONS

CEWELD® 347H is designed for welding high-carbon 18/8 steels, especially titanium- and niobium-stabilized steels such as 321H and 347H.
Main applications include catalytic crackers (also known as "cat crackers"), cyclones, transfer lines, furnace components, steam lines, superheater manifolds, and various components of gas and steam turbines. The product is widely used in petrochemical plants, the chemical industry, and power generation.

PROPERTIES

CEWELD® 347H has a carbon content of 0.04 to 0.08%, which gives the compound increased mechanical and structural strength at high temperatures up to approximately 800 °C.
The niobium it contains prevents intergranular corrosion, even under particularly demanding operating conditions.
For base materials with a thickness greater than 12 mm, CEWELD® 18.8.2 should be used.

CLASSIFICATION

AWS	A 5.9: ER347
EN ISO	14343-A: G 19 9 Nb
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, 1.4878, *(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

APPROVALS

CE

WELDING POSITIONS

TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	Cr	Ni	Mo	Nb	Cu
0.055	0.9	0.7	19	10	0.05	0.4	0.07

MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Impact Energy (J) ISO-V		Hardness
				-50°C	RT	
As Welded	450	660	42	80	100	HRc

REDRYING

Not required

GAS ACC. EN ISO 14175

M12, M13