



CEWELD AA 347H

TYPE	Rutile fluxcored wire for welding stabilized stainless steel								
APPLICATIONS	For welding stainless austenitic steels that are exposed to working temperatures up to + 400°C.								
PROPRIÉTÉS	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.								
CLASSIFICATION	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							
CONVIENT POUR	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								
AGRÉMENTS									
POSITIONS DE SOUDAGE	PAPBPCPDPEPFPG								
ANALYSE CHIMIQUE TYPIQUE DU MÉTAL DE SOUDURE (%)	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
PROPRIÉTÉS MÉCANIQUES	Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A5 (%)	Impact Energy (J) ISO-V			Hardness	
	As Welded	440	620	37	RT			HRc	
ETUVAGE	140°C / 24 hr								
GAS ACC. EN ISO 14175	M21								



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AA 347H 1,2MM

Packaging	KG/unit	EanCode
BS-300	15	8720663413604