



# CEWELD 327

<b>TYPE</b>	Solid stainless steel welding wire for high temperature applications					
<b>APPLICATIONS</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>PROPRIÉTÉS</b>	High chromium-alloyed welding wire 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>CLASSIFICATION</b>	EN ISO	14343-A: G 25 4				
	W.Nr.	1.4820				
	F-nr	6				
	FM	5				
<b>CONVIENT POUR</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					
<b>AGRÉMENTS</b>	CE					
<b>POSITIONS DE SOUDAGE</b>						
<b>ANALYSE CHIMIQUE TYPIQUE DU MÉTAL D'APPORT (%)</b>	C	Si	Mn	Cr	Ni	
	0.1	0.6	2	26	5	
<b>PROPRIÉTÉS MÉCANIQUES</b>	Heat Treatment	R <sub>P0,2</sub> (MPa)	R <sub>m</sub> (MPa)	A5 (%)	Impact Energy (J) ISO-V -20°C	Hardness
	As Welded	450	660	15	50	HRc
<b>ETUVAGE</b>	Not required					
<b>GAS ACC. EN ISO 14175</b>	M11, M12					



# CEWELD 327

327 1,0MM

Packaging	KG/unit	EanCode
BS-300	15	8720663415844

327 1,2MM

Packaging	KG/unit	EanCode
BS-300	15	8720663415851

327 1,6MM

Packaging	KG/unit	EanCode
BS-300	15	8720663415868