



CEWELD AA 347 Tig

TYPE	Flux cored stainless steel welding wire for Tig welding							
APPLICATIONS	Boilers, shipbuilding, machinery, offshore application, foundries, chemical industry, root pass welding when backing gas is not available or preferred.							
PROPRIÉTÉS	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.							
CLASSIFICATION	AWS	A 5.22: R347T1-5						
	W.Nr.	1.4550						
	F-nr	6						
	FM	5						
CONVIENT POUR	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							
AGRÉMENTS								
POSITIONS DE SOUDAGE	 PA  PB  PC  PD  PE  PF							
ANALYSE CHIMIQUE TYPIQUE DU MÉTAL DE SOUDURE (%)	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
PROPRIÉTÉS MÉCANIQUES	Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A5 (%)	Impact Energy (J) ISO-V		Hardness	
					RT			
	As Welded	460	630	48	130		HRc	
ETUVAGE	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