



# 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.                                                                                                                                                                                                                                                                                                                                                                                                                                               |                         |                      |                    |                         |      |          |       |
| PROPERTIES                                  | 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                       |                      |                    |                         |      |          |       |
| SUITABLE FOR                                | <b>ISO 15608: 8.1 / TÜV Groupe 29 (+22+21) / E347, 19 9 Nb, 1.4551</b><br>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)<br>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,<br>X 5CrNi 18 12 G-X, 6CrNi 18 9, X 12CrNi 17 7, G-X 10CrNi 18 8<br>AISI: 321, 347                                                                                                                                                                                |                         |                      |                    |                         |      |          |       |
| APPROVALS                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |                         |                      |                    |                         |      |          |       |
| WELDING POSITIONS                           | <div> PA</div> <div> PB</div> <div> PC</div> <div> PD</div> <div> PE</div> <div> PF</div> |                         |                      |                    |                         |      |          |       |
| TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%) | 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   |
| MECHANICAL PROPERTIES                       | 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                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             | 460                     | 630                  | 48                 | 130                     |      | HRc      |       |
| REDRYING                                    | Not required                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |                         |                      |                    |                         |      |          |       |
| GAS ACC. EN ISO 14175                       | I1                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    |                         |                      |                    |                         |      |          |       |



# CEWELD AA 347 Tig

|                         |           |         |               |
|-------------------------|-----------|---------|---------------|
| AA 347 TIG 2,2 X 1000MM | Packaging | KG/unit | EanCode       |
|                         | Tube      | 5       | 8720663413611 |