



# CEWELD SA 347

**TYPE** Solid stainless steel welding wire for submerged arc welding 18Cr/10Ni alloys stabilized with Ti of Nb

**APPLICATIONS** Solid stainless steel wire for SAW welding Niobium or Titanium stabilized stainless steels.

**PROPRIÉTÉS** This wire can be used for stainless steels stabilized with Ti of Nb like grades 321 and 347. But also for unstabilized alloys like 304 or 304L. High resistance against intergranular corrosion. Fused flux FL 880 of agglomerated flux FL 838 can be used

**CLASSIFICATION**

|        |                    |
|--------|--------------------|
| AWS    | A 5.9: ER347       |
| EN ISO | 14343-A: S 19 9 Nb |
| W.Nr.  | 1.4551             |
| F-nr   | 6                  |
| FM     | 5                  |

**CONVIENT POUR** 1.4541, 1.4550, 1.4552 1.4319, 1.4306, 1.4306, 1.4301, 1.4303, 1.4308, 1.4310, 1.4312, 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: 321, 347

**AGRÉMENTS** CE

**POSITIONS DE SOUDAGE**



**ANALYSE CHIMIQUE TYPIQUE DU MÉTAL D'APPORT (%)**

| C    | Si  | Mn | P    | S    | Cr | Ni | Nb  |
|------|-----|----|------|------|----|----|-----|
| 0.06 | 0.5 | 2  | 0.02 | 0.02 | 20 | 10 | 0.1 |

**PROPRIÉTÉS MÉCANIQUES**

| Heat Treatment | R <sub>P0,2</sub> (MPa) | R <sub>m</sub> (MPa) | A <sub>5</sub> (%) | Impact Energy (J) ISO-V |        | Hardness |
|----------------|-------------------------|----------------------|--------------------|-------------------------|--------|----------|
|                |                         |                      |                    | RT                      | -196°C |          |
| As Welded      | 380                     | 600                  | 35                 | 80                      | 40     | HRc      |

**ETUVAGE** Not required

**GAS ACC. EN ISO 14175**