



CEWELD 347Si Tig

TYPE	Filler metal for welding stabilized stainless austenitic steels 18/8. (Type 19 9 Nb, 347Si)									
APPLICATIONS	CEWELD® 347Si Tig is designed for welding 18/8 steels, particularly types 321 and 347. It is also compatible with non-stabilized grades such as 304/304L. Typical operating temperatures range from -100 °C to approximately 400 °C. Main application areas include the food processing industry, breweries, pharmaceutical plants, construction, general engineering, and nuclear technology.									
PROPERTIES	CEWELD® 347Si Tig is suitable for low-temperature applications where a low carbon content and controlled ferrite content are recommended. This is demonstrated by its excellent impact strength values of ~200 J at -50 °C (>47 J down to -110°C). CEWELD® 347Si can be welded without preheating at a maximum interpass temperature of 250 °C. Post-weld heat treatment (PWHT) is not necessary. However, CEWELD® 347Si Tig is not recommended for high-temperature structural components where a carbon content between 0.04% and 0.08% is required for creep resistance. In this case, welding consumables from the 347H series are recommended (see CEWELD® 347H Tig).									
CLASSIFICATION	AWS	A 5.9: ER347Si								
	EN ISO	14343-A: W 19 9 Nb Si								
	W.Nr.	1.4551								
	F-nr	6								
	FM	5								
SUITABLE FOR	ISO 15608: 8.1 (no Mo) 347, 19 9 Nb, 1.4551 1.4000, 1.4001, 1.4002, 1.4003, 1.4006, 1.4301, 1.4303, 1.4306, 1.4308, 1.4310, 1.4311, 1.4312, 1.4319, 1.4541, 1.4543, 1.4546, 1.4550, 1.4552, 1.4561, 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 UNS S30400, S30403, S30453, S32100, S34700 AISI 347, 321, 302, 304, 304L, 304LN, CF8C									
APPROVALS	TÜV: (12392), CE									
WELDING POSITIONS	      									
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	C	Si	Mn	P	S	Cr	Ni	Mo	Nb	Cu
	0.04	0.7	1	0.007	0.01	20	10	0.05	0.4	0.07
MECHANICAL PROPERTIES	Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness		
					-110°C		-60°C			
	As Welded	450	610	35	150		200		HRc	
REDRYING	Not required									
GAS ACC. EN ISO 14175	I1									



CEWELD 347Si Tig

347SI TIG 1,0 X 1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663412843

347SI TIG 1,2 X 1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663412850

347SI TIG 1,6 X 1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663412881

347SI TIG 2,0 X 1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663412898

347SI TIG 2,4 X 1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663412904

347SI TIG 3,2 X 1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663412911