CEWELD 327 Tig

certilas® THE FILLER METAL SPECIALIST

TYPE

Solid stainless steel welding wire for high temperature applications. (Mo free 25 4, 327)

APPLICATIONS

CEWELD® 327 Tig is a high-alloy solid rod suitable for production and repair welding on similar or similar corrosion- and heat-resistant steels and steel castings. For furnaces that require improved resistance to reducing and oxidizing sulfur-containing gases, as well as for welding welded joints. Resistant to spalling up to 1100 °C.

PROPERTIES

CEWELD® 327 Tig produces a weld metal with 25% chromium and 4% nickel for build-up welding and joining components that must be corrosion, heat, and wear resistant. It is characterized by excellent weld quality and X-ray resistance, has a stable arc at high currents, and a coating that is easy to machine.

CLASSIFICATION

EN ISO	14343-A: W 25 4
W.Nr.	1.4820
F-nr	6
FM	5

SUITABLE FOR

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

APPROVALS

WELDING POSITIONS

TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

C	Si	Mn	Cr	Ni
0.1	0.6	2	26	5

MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Impact Energy (J) ISO-V	Hardness
				-20°C	
As Welded	450	660	15	55	HRc

REDRYING

Not required

GAS ACC. EN ISO 14175

CEWELD 327 Tig

327 TIG 1,6 X 1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663415899

327 TIG 3,2 X 1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663415929