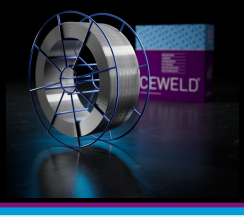


CEWELD 327

certilas® THE FILLER METAL SPECIALIST

TYPE	Solid stainless steel welding wire for high temperature applications
APPLICATIONS	Cap layers for joining refractory Cr-Al-Si steels, cladding corrosion resistant overlays, cladding heat resistant overlays up to 1100°C, cladding components in a sulphurous environment.
PROPRIÉTÉS	High chromium-alloyed welding wire based on a 25% Chromium and 4% Nickel deposit for cladding and joining components against corrosion, high-heat and wear resistance Excellent weld metal quality and X-ray soundness, stable arc at high currents and good machinable deposit.

CLASSIFICATION

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

CONVIENT POUR

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

AGRÉMENTS

CE

POSITIONS DE SOUDAGE

TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

C	Si	Mn	Cr	Ni
0.1	0.6	2	26	5

PROPRIÉTÉS MÉCANIQUES

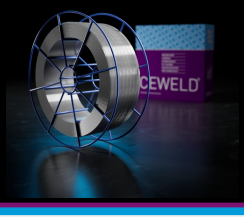
Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Impact Energy (J) ISO-V	Hardness
				-20°C	
As Welded	450	660	15	50	HRc

ETUVAGE

Not required

GAS ACC. EN ISO 14175

M11, M12



CEWELD 327

327 1,0MM

Packaging	KG/unit	EanCode
BS-300	15	8720663415844

327 1,2MM

Packaging	KG/unit	EanCode
BS-300	15	8720663415851

327 1,6MM

Packaging	KG/unit	EanCode
BS-300	15	8720663415868