

327

CATEGORY	GMAW-GTAW Solid wires																												
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.																												
PROPERTIES	High chromium-alloyed welding wire (ER 327-ER 329) 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	AWS	A 5.9: ER 327 (~329)																											
	EN ISO	14343-A: G 25 4																											
	DIN: W.Nr.	1.4820																											
	DIN	8556: X 12 CrNi 25 4																											
SUITABLE FOR	W.Nr:	EN ASTM/ACI	W.Nr:	EN ASTM/ACI																									
	1.4710	G-X30CrSi6	1.4724	X10CrAl13 TP405-CA15																									
	1.4745	G-X40CrSi23 TP433	1.4820	G-X12 CrSi 26 5																									
	1.4712	X10CrSi6 502	1.4729	G-X40CrSi13																									
	1.4762	X10CrAl24 TP443	1.4821	X20 CrNiSi 25 4 TP329																									
	1.4713	X10CrAl7 502	1.4740	G-X40CrSi17																									
	1.4773	X8Cr30	1.4822	G-X40CrNi 25 4 TP329																									
	1.4722	X10CrSi13	1.4742	X10CrAl18 430B-TP430																									
	1.4776	G-X40CrSi29	1.4823	G-X40CrNiSi 27 4 TP329HC																									
APPROVALS	CE approved																												
WELDING POSITIONS:																													
TYPICAL DEPOSIT WEIGHT %	<table border="1"> <thead> <tr> <th>C</th> <th>Si</th> <th>Mn</th> <th>Cr</th> <th>Ni</th> <th></th> </tr> </thead> <tbody> <tr> <td>0.10</td> <td>0.6</td> <td>1.0-2.5</td> <td>24-27</td> <td>4-6</td> <td>0.020</td> </tr> </tbody> </table>					C	Si	Mn	Cr	Ni		0.10	0.6	1.0-2.5	24-27	4-6	0.020												
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