

307 Si Tig

CATEGORY GMAW-GTAW Solid wires

TYPE Tig welding wire for dissimilar welding and buffer layers

APPLICATIONS Buffer layers before hardfacing, dissimilar welding between steel and stainless steel, armor plate, exhaust systems (type 409, 304), high Manganese austenitic steel, heterogeneous welding, difficult to weld steels etc.

PROPERTIES Corrosion resistance is equivalent to type 304, high mechanical properties and good weldability, work hardening and cold-tough to -110°C.

CLASSIFICATION

AWS	A 5.9: ER 307 (mod.)
EN ISO	14343-A: W 18 8 MnSi
	14343-B: SSZ 307
DIN: W.Nr.	1.4370
DIN	8556: SG X15CrNiMn 18 8

SUITABLE FOR Dissimilar welding between steel and stainless steel, armor plate, exhaust systems (type 409, 304), high Manganese austenitic steel, difficult to weld steels such as: 42CrMo4, C45, 42MnV7, tool steels, 1.3401, X120Mn12 etc.

APPROVALS CE approved

WELDING POSITIONS:



TYPICAL ALL WELD METAL ANALYSIS

C	Mn	Si	Cr	Ni
0.12	6.5	1.0	18.5	8.5

MECHANICAL PROPERTIES

Heat treatment	RP0,2 (N/mm2)	Rm (N/mm2)	A5 (%)	Impact energy (J) ISO-V			Hardness HRc / HV
				+20C	-40°C	-60C	
AW	>350	>600	40	>100			

AW: as welded

WELDING PARAMETERS / PACKING

D (mm)	Welding Parameters	Packing (kg)	
	Current (A) DC-	single	master
1.6 x 1000	50-80	5	25
2.0 x 1000	70-110	5	25
2.4 x 1000	110-180	5	25
3.2 x 1000	150-250	5	25

REDRYING TEMPERATURE not required

GAS ACC. EN ISO 14175: I1