

## 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** TUV (12385.00) , DB (43.206.01) 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