

TIG 307Si



TIG 307Si is for use on dissimilar combinations of CMn, stainless, hardenable, wear-resistant and armour steels. Also suitable for 13% Mn manganese (Hadfield) steel and mixed welding applications. Can be used as buffer layers and a surfacing consumable.

CLASSIFICATIONS

AWS	A5.9	Similar to ER307
BS EN	12072	18 8 Mn Si
DIN	8556	SG-X 15 CrNiMn 18 8 (1.4370)

CHEMICAL ANALYSIS

% Carbon	0.08	% Chromium	19.00
% Manganese	6.00	% Nickel	8.50
% Silicon	0.80	% Molybdenum	0.20
% Sulphur	0.01	% Copper	0.10
% Phosphorus	0.015		

**TYPICAL MECHANICAL PROPERTIES
ALL WELD METAL**

Tensile Strength	605 MPa
0.2% Proof Stress	414 MPa
Elongation on 4d	42%
Charpy V-Notch 20°C	105J
Charpy V-Notch -50°C	65J

Microstructure
In the as-welded condition the weld metal microstructure is fully austenitic.

* Flux Dependant

PACKING DATA

TIG (DC-)

Diameter (mm)	Current		Item Number	Pack Mass (Kg)
	Amps	Volts		
1.60	100	12	030-405	5
2.40	100	12	030-407	5

Suggested Shielding Gas: Argon

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