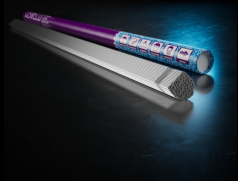




CEWELD 307Si Tig

TYPE	Tig welding rod for dissimilar welding and buffer layers. (Type 18 8 Mn, 1.4370)					
APPLICATIONS	CEWELD® 307Si Tig is for 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. The deposit work hardens from 200 HV to 450 HV.					
PROPERTIES	CEWELD® 307Si Tig is corrosion-resistant and equivalent to Type 304. The wire has high mechanical properties, is easily welded and is tough down to -196°C. The deposit work hardens from 200 HV to 450 HV.					
CLASSIFICATION	AWS	A 5.9: ~ER 307				
	EN ISO	14343-A: W 18 8 Mn				
	W.Nr.	1.4370				
	F-nr	6				
	FM	5				
SUITABLE FOR	19% Cr / 9% Ni / 7% Mn, ISO 15608: 8.1 Cr ≤ 19 % 1.3401, 1.5637, 1.5680, 1.4370 X 20 Cr 13, X 8 Cr 17, X 22 CrNi 17, X 5 CrNi 17, G-X 20 Cr 14 mix S355 42CrMo4, C45, 42MnV7, X120Mn12, 10 Ni 14, 12 Ni 19 etc. ASTM 307, 304, (409, 403, 405, 410, 420, 430, 440, 501, 502) Amor					
APPROVALS	CE					
WELDING POSITIONS	      					
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	C	Si	Mn	Cr	Ni	
	0.12	0.9	6	18.5	8.5	
MECHANICAL PROPERTIES	Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V	Hardness
	As Welded	420	615	40	-196°C	
					45	HRc
REDRYING	Not required					
GAS ACC. EN ISO 14175	I1					



CEWELD 307Si Tig

307SI TIG 1,0 X 1000MM	Packaging	KG/unit	EanCode
	Tube	5	8720663412225
307SI TIG 1,2 X 1000MM	Packaging	KG/unit	EanCode
	Tube	5	8720663412232
307SI TIG 1,6 X 1000MM	Packaging	KG/unit	EanCode
	Tube	5	8720663412249
307SI TIG 2,0 X 1000MM	Packaging	KG/unit	EanCode
	Tube	5	8720663412256
307SI TIG 2,4 X 1000MM	Packaging	KG/unit	EanCode
	Tube	5	8720663412263
307SI TIG 3,2 X 1000MM	Packaging	KG/unit	EanCode
	Tube	5	8720663412270
307SI TIG 4,0 X 1000MM	Packaging	KG/unit	EanCode
	Tube	5	8720663412287