



CEWELD 307Si

TYPE	Stainless steel 307Si Type Mig/Mag wire for GMAW dissimilar welding and buffer layers(1.4370)					
APPLICATIONS	CEWELD® 307Si 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.					
PROPERTIES	CEWELD® 307Si 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: G 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	TÜV: 12385, CE, DB: 43.206.01					
WELDING POSITIONS	PA PB PC PD PE PF					
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	C	Si	Mn	Cr	Ni	
	0.09	0.9	6	18	8	
MECHANICAL PROPERTIES	Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V	Hardness
	As Welded	400	600	40	-196°C 40	HRc
REDRYING	Not required					
GAS ACC. EN ISO 14175	M11, M13, M12					



CEWELD 307Si

307SI 0,8MM

Packaging	KG/unit	EanCode
BS-300	15	8720663417541
D-200	5	8720663417558

307SI 1,0MM

Packaging	KG/unit	EanCode
BS-300	15	8720663417565
D-200	5	8720663417572
Drum	250	8720663417589

307SI 1,2MM

Packaging	KG/unit	EanCode
BS-300	15	8720663417596
D-200	5	8720663417619
Drum	250	8720663417602

307SI 1,6MM

Packaging	KG/unit	EanCode
BS-300	15	8720663417626
Drum	250	8720663417633