

STAINLESS STEEL FILLER METAL

special type

ER 307Si SGB

DESCRIPTION and APPLICATIONS

Austenitic stainless steel filler metal suitable for welding dissimilar steels like austenitic manganese steel and carbon steel. It is often used as weld layer before making the hard facing. Equivalent to ER 307 SGB except for higher Si content. This improves the arc stability, the weld metal fluidity and the melt run appearance.

Chemical composition product analysis % by mass (single value means maximum value if not different stated)

C	Si	Mn	P	S	Cr	Ni	Mo	N	Cu	Nb	W	other
0,04	0,65	5,5	0,03	0,02	17,5	8,0	0,3	-	0,3	-	-	0,5
0,14	1,2	7,5			19,5	10,0						

Specifications	Designations
EN ISO 14343-A	18 8 Mn Si
AWS A5.9	-

Approvals		
MIG	X	-

Expected Minimum mechanical properties of all weld metal *	Typical Results
Proof strenght Rp0,2 [Mpa]	350
Tensile strenght Rm [Mpa]	500
Elongation [%]	25
Impact strength KV at - 40°C [J]	90
(*) : Room temperature if not different stated	

WELDING FILLER METAL SPECIFIC TO	AVAILABLE DIAMETERS [mm]							
	0,8	1,0	1,2	1,6	2,0	2,4	3,2	4,0
MIG, PLASMA, PLASMA MIG, LASER								
TIG								

PACKAGING TYPE		WIRE RANGE DIAMETERS [mm]	INNER PACKAGING DIAMETER [mm]	OUTER PACKAGING DIAMETER [mm]	NUMBER OF PIECES PER PACKAGING	WEIGHT [kg]	WINDING TYPE
	K300	0,8÷1,6	52	300	60 spools every pallet	15	Precision layer
	RODS	1,0÷4,0 (lenght 1 m)	-	-	-	5	-