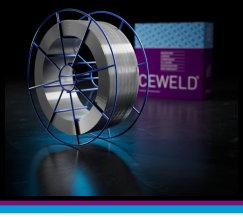


certilas® THE FILLER METAL SPECIALIST

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. The deposit work hardens from 200 HV to 450 HV.
PROPERTIES	Corrosion resistance is equivalent to type 304, high mechanical properties and good weldability, work hardening and cold-tough to -196°C.

CLASSIFICATION

AWS	A 5.9: ~ER 307
EN ISO	14343-A: G 18 8 Mn
F-nr	6
FM	5
W.Nr.	1.4370

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 (12385.02) CE DB (43.206.01)

WELDING POSITIONS

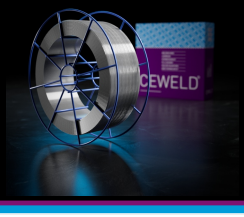
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

C	Si	Mn	Cr	Ni
0.09	0.9	6	18	8

ALL WELD MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ MPa	Rm MPa	A5 (%)	Impact Energy (J) ISO-V -196°C
As Welded /	400	600	40	40

REDRYING TEMPERATURE	Not required
GAS ACCORDING EN 14175	M11, M13, M12



CEWELD 307Si

certilas® THE FILLER METAL SPECIALIST

307SI 0,8MM

Type	KG/unit	EANCode
BS-300	15	8720663417541
D-200	5	8720663417558

307SI 1,0MM

Type	KG/unit	EANCode
BS-300	15	8720663417565
D-200	5	8720663417572
Drum	250	8720663417589

307SI 1,2MM

Type	KG/unit	EANCode
BS-300	15	8720663417596
D-200	5	8720663417619
Drum	250	8720663417602

307SI 1,6MM

Type	KG/unit	EANCode
BS-300	15	8720663417626
Drum	250	8720663417633