



# 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			
	F-nr	6			
	FM	5			
	W.Nr.	1.4370			
SUITABLE FOR	<b>19% Cr / 9% Ni / 7% Mn, ISO 15608: 8.1 Cr ≤ 19 %</b> 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					
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 <sub>P0,2</sub> MPa	R <sub>m</sub> 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

## 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