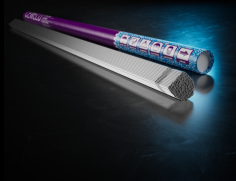


CEWELD 307Si Tig

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			
	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	CE				
WELDING POSITIONS	      				
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	C	Si	Mn	Cr	Ni
	0.12	0.9	6	18.5	8.5
ALL WELD MECHANICAL PROPERTIES	Heat Treatment	R _{P0,2} MPa	R _m MPa	A ₅ (%)	Impact Energy (J) ISO-V -196°C
	As Welded /	420	615	40	45
REDRYING TEMPERATURE	Not required				
GAS ACCORDING EN 14175	I1				



CEWELD 307Si Tig

307SI TIG 1,0 X 1000MM

Type	KG/unit	EANCode
Tube	5	8720663412225

307SI TIG 1,2 X 1000MM

Type	KG/unit	EANCode
Tube	5	8720663412232

307SI TIG 1,6 X 1000MM

Type	KG/unit	EANCode
Tube	5	8720663412249

307SI TIG 2,0 X 1000MM

Type	KG/unit	EANCode
Tube	5	8720663412256

307SI TIG 2,4 X 1000MM

Type	KG/unit	EANCode
Tube	5	8720663412263

307SI TIG 3,2 X 1000MM

Type	KG/unit	EANCode
Tube	5	8720663412270

307SI TIG 4,0 X 1000MM

Type	KG/unit	EANCode
Tube	5	8720663412287