

MI 307SI

Gazaltı (MIG/MAG) Kaynak Teli - Stainless Steels

Standards

AWS/ASME SFA - 5.9	~ER307
EN ISO 14343 - A	G 18 8 Mn
TS EN ISO 14343 - A	G 18 8 Mn
DIN M. No.	1.4370

Materials

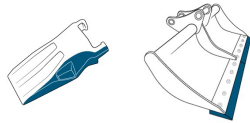
Width	Material	ASTM
X3CrNiMo17-13-3	1.4436	316
X5CrNi18-10	1.4301	304
X6CrNiMoTi17-12-2	1.4571	316 Ti
X10CrNiMo 18-12	1.4583	318

Properties and Applications

Austenitic stainless steel wire electrode for GMA (MIG/MAG) welding of dissimilar steels, difficult to weld steels, armour plates, high manganese steels, rails, crossovers. Suitable also for depositing stress relaxing buffer layers on crack sensitive base metals and hardfacing jobs, e.g. crane wheel surfacing where high degree of pressure and dynamical loads exists. Weld metal has a high degree of corrosion resistance and resistant to operating temperatures up to 300°C and non-scalding up to 850°C. Observe welding procedures, preheating temperature and avoid high admixture of base metal.



Typical Applications



Typical Chemical Features of the Welding Wire

Type of Analysis	C	Si	Mn	Cr	Ni
Welding Wire	0.07	0.80	7.00	18.00	8.00

Typical Mechanical Values of Weld Metal

Test Condition	Protection Gas	Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Elongation A5 (%)	Charpy V-Notch Properties (J)
As welded	M13	460	630	39	20°C → 90 -20°C → 60

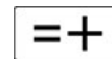
* Chemical composition and mechanical properties are valid when using shielding gas EN ISO 14175 - M13 (Ar+%0,5-3 O2) .

Application Information

Welding Positions



Polarity:



Protection Gas:

M13 M12 M14 I1

Welding Parameters & Efficiency

Diameter (mm)
1.00
1.20
1.60

Packaging Information

Product Code	Diameter (mm)	Quantity per Box	Box Gross Weight (kg)	Boxes per Outer Box	Outer Box Gross Weight (kg)	Packaging Type
23000DJAM2	1.00	15 kg	15.70	1	15.70	Wire Basket Spool (K300MS)

23000EBAM2	1.20	5 kg	5.30	1	5.30	Plastic Spool (D200)
23000EJAM2	1.20	15 kg	15.70	1	15.70	Wire Basket Spool (K300MS)
23000GJAM2	1.60	15 kg	15.70	1	15.70	Wire Basket Spool (K300MS)

Storage & Re-Drying Information

Shouldn't be exposed to high statical load and impact.