

SI 307

Submerged Arc Welding Wire - Stainless Steels

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

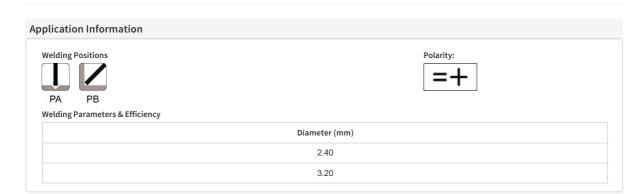
Properties and Applications

Austenitic stainless steel welding wire for submerged arc welding of dissimilar steels, difficult to weld steels, armour plates, high manganese steels, rails, crossovers. Suitable also for depositing stress relieving buffer layers on crack sensitive base metals and hardsurfacing, e.g. crane wheels, cutting blades and dies where high degree of pressure and dynamical loads exists. Weld metal is resistant to operating temperatures up to 300°C and non-scalling up to 850°C and also highly corrosion resistant. Used in combination with SIF 501 and SIF 502 submerged arc welding fluxes. Depending on chemical composition of base metal, proper welding procedure, preheating and interpass temperatures shall be applied by also avoiding high admixture of base metal.

Typical Chemical Features of the Welding Wire									
Type of Analysis	С	Si	Mn	Cr	Ni				
Welding Wire	0.02	0.90	5.00	19.00	8.00				

Typical Chemical Values of Weld Metal Welding Flux Type of Analysis С Si Mn Cr Ni SIF 502 Weld Deposit 0.04 0.90 5.00 18.50 8.00 SIF 501 Weld Deposit 0.04 0.85 5.50 18.50 7.00

Typical Mechanical Values of Weld Metal Tensile Strength (N/mm²) Test Condition Welding Flux Yield Strength (N/mm²) Elongation A5 (%) Charpy V-Notch Properties (J) As welded SIF 502 420 610 $20^{\circ}C \rightarrow 60$ -60°C → 45 As welded SIF 501 410 600 42 $20^{\circ}C \rightarrow 70$ -60°C → 50



Packaging Information									
Product Code	Diameter (mm)	Quantity per Box	Box Gross Weight (kg)	Boxes per Outer Box	Outer Box Gross Weight (kg)	Packaging Type			
43000IXAM2	2.40	25 kg	25.90	1	25.90	Wire Basket Spool (K435)			
43000LXAM2	3.20	25 kg	25.90	1	25.90	Wire Basket Spool (K435)			

Storage & Re-Drying Information

Shouldn t be exposed to high statical load and impact. It should be stored in a dry room (relative humidity <50%, room temperature $>20^\circ\!C$) on wooden pallets.