



AWS A5.9: ER307~
ISO 14343 -A-2009 18 8 Mn~

Stainless Steel Solid Wire

MIG Welding

SW-307Si

DESCRIPTION & APPLICATION

MIG Filler wire for the joining and overlay of Stainless Steels of similar composition. Joining of all Austenitic Stainless as well as 14% Manganese. Used to join Wear Plates and as a buffer layer under hard surfacing. Fully Austenitic deposit, non-magnetic with high ductility. Increased Silicon content compared with standard, gives more fluid deposit.

BASE MATERIALS

All 300 series Austenitic Stainless Steel, 14% Manganese Steel, Railway and Crane Tracking, Wear Plates, Buffer layer on manganese or high carbon/high manganese steel prior to hard facing.

MECHANICAL PROPERTIES

~650n/mm
UTS n/mm

>460

YIELD 0.2%

~30

ELONG A5%

140-200

HARDNESS HV

METAL WELD COMPOSITION %

C

0.15

Si

0.95

Mn

7.0

Cr

18.5

Ni

8.5

Mo

0.3

S

0.02

P

0.025

Fe

BAL

PACKAGING

15kg Spools (MIG)

DIAMETERS

0.8, 1.0, 1.2, 1.6mm (MIG)

WELDING INSTRUCTIONS

Shielding gas 5% or 20% in Argon, or 2% Argon-Ox. Do not allow the base material to overheat, particularly when welding Manganese Steel.

For more details on welding of Stainless steel, please see our Information Sheets.
Visit: www.westbrookwelding.co.uk/downloads