

## ELBOR STAINLESS STEEL MIG WIRE AWS A 5.9 307 SI

*The 307Si produces a tough, ductile, 19% Cr / 9% Ni / 7% Mn austenitic stainless weld metal which is highly crack resistant. It is intended for joining hardenable steels, armour plate, 13% Mn steels and difficult-to-weld steels, without the need for preheat. It is also recommended for dissimilar joints between stainless and mild or medium carbon steels. Welds produced with 307Si can be PWHT without risk of sigma-phase formation and consequent loss of ductility. The deposit work hardens from 200 HV to 450 HV.*

*APPLICATIONS: Buffer layers on 13% Mn steels used in rock crushing and earth moving equipment, prior to hardfacing. Reclaiming 13% Mn steels. Surfacing of rails, rail crossings, frogs etc. Buffer layers in highly restrained repair work.*

**NORM: EN ISO 14343-A-G18 8Mn - WERKSTOFF. 1.4370**

**MATERIAL TO BE WELD :**

**STEELS 14% Mn - STEELS 13%-17% Cr.**

**TYPICAL CHEMICAL CONTENT : ANALISI CHIMICA TIPICA**

Mo	0.10-0.15
Cr	18.00-20.00
Ni	11.00-13.00
Mn	6.00-8.00
Si	0.65-1.00
Cu	0.10
C	0.04

**AWS A 5.9: ER307Si  
EN ISO 14343-A: G 18 8 Mn**

Elongation	30 %
Impact Strenght Kv (+20°C)	>47 J
Tensile Strenght	580 MPa
Yeld Strenght	410 MPa

**Welding positions :**



Tutte le posizioni