



# CEWELD 307Si

**TYPE** Stainless steel 307Si Type Mig/Mag wire for GMAW dissimilar welding and buffer layers(1.4370)

**APPLICATIONS** CEWELD 307Si 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** Corrosion resistance is equivalent to type 304, high mechanical properties and good weldability, work hardening and cold-tough to -196°C.

**CLASSIFICATION**

AWS	A 5.9: ~ER 307
EN ISO	14343-A: G 18 8 Mn
W.Nr.	1.4370
F-nr	6
FM	5

**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** TÜV: 12385.02, CE, DB: 43.206.01

**WELDING POSITIONS**



**TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)**

C	Si	Mn	Cr	Ni
0.09	0.9	6	18	8

**MECHANICAL PROPERTIES**

Heat Treatment	Rp0,2 (MPa)	Rm (MPa)	A5 (%)	Impact Energy (J) ISO-V	Hardness
				-196°C	
As Welded	400	600	40	40	HRc

**REDRYING** Not required

**GAS ACC. EN ISO 14175** M11, M13, M12



# CEWELD 307Si

## 307SI 0,8MM

Packaging	KG/unit	EanCode
BS-300	15	8720663417541
D-200	5	8720663417558

## 307SI 1,0MM

Packaging	KG/unit	EanCode
BS-300	15	8720663417565
D-200	5	8720663417572
Drum	250	8720663417589

## 307SI 1,2MM

Packaging	KG/unit	EanCode
BS-300	15	8720663417596
D-200	5	8720663417619
Drum	250	8720663417602

## 307SI 1,6MM

Packaging	KG/unit	EanCode
BS-300	15	8720663417626
Drum	250	8720663417633