




# CEWELD 307Si

| TYPE  | Fil de soudage acier inoxydable 307 Si  |                |                         |                      |                    |                         |          |                    |                         |          |     |    |    |     |
|---|---|----------------|-------------------------|----------------------|--------------------|-------------------------|----------|--------------------|-------------------------|----------|-----|----|----|-----|
| APPLICATIONS                                      | Couches beurrage avant rechargement, soudure hétérogènes entre l'acier et l'acier inoxydable, plaques de blindage, systèmes d'échappement (type 409, 304), acier austénitique à haute teneur en manganèse, soudure hétérogène, acier difficile à souder, etc.   |                |                         |                      |                    |                         |          |                    |                         |          |     |    |    |     |
| PROPRIÉTÉS  | Résistance à la corrosion équivalente à celle du type 304, propriétés mécaniques élevées et bonne soudabilité, durcissement par écrouissage et résistance au froid jusqu'à -110°C.  |                |                         |                      |                    |                         |          |                    |                         |          |     |    |    |     |
| CLASSIFICATION                                    | <table border="0"> <tr> <td>AWS</td> <td>A 5.9: ~ER 307</td> </tr> <tr> <td>EN ISO</td> <td>14343-A: G 18 8 Mn</td> </tr> <tr> <td>W.Nr.</td> <td>1.4370</td> </tr> <tr> <td>F-nr</td> <td>6</td> </tr> <tr> <td>FM</td> <td>5</td> </tr> </table>  | AWS            | A 5.9: ~ER 307          | EN ISO               | 14343-A: G 18 8 Mn | W.Nr.                   | 1.4370   | F-nr               | 6                       | FM       | 5   |    |    |     |
| AWS   | A 5.9: ~ER 307  |                |                         |                      |                    |                         |          |                    |                         |          |     |    |    |     |
| EN ISO  | 14343-A: G 18 8 Mn  |                |                         |                      |                    |                         |          |                    |                         |          |     |    |    |     |
| W.Nr.   | 1.4370  |                |                         |                      |                    |                         |          |                    |                         |          |     |    |    |     |
| F-nr  | 6   |                |                         |                      |                    |                         |          |                    |                         |          |     |    |    |     |
| FM  | 5   |                |                         |                      |                    |                         |          |                    |                         |          |     |    |    |     |
| CONVIENT POUR                                     | <p><b>19% Cr / 9% Ni / 7% Mn, ISO 15608: 8.1 Cr ≤ 19 %</b><br/>           1.3401, 1.5637, 1.5680, 1.4370<br/>           X 20 Cr 13, X 8 Cr 17, X 22 CrNi 17, X 5 CrNi 17, G-X 20 Cr 14 mix S355<br/>           42CrMo4, C45, 42MnV7, X120Mn12, 10 Ni 14, 12 Ni 19 etc.<br/>           ASTM 307, 304, (409, 403, 405, 410, 420, 430, 440, 501, 502)<br/>           Amor</p>  |                |                         |                      |                    |                         |          |                    |                         |          |     |    |    |     |
| AGRÉMENTS   | TÜV: 12385.02, CE, DB: 43.206.01  |                |                         |                      |                    |                         |          |                    |                         |          |     |    |    |     |
| POSITIONS DE SOUDAGE                              |   |                |                         |                      |                    |                         |          |                    |                         |          |     |    |    |     |
| TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%) | <table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <tr> <td style="width: 25%;">C</td> <td style="width: 25%;">Si</td> <td style="width: 25%;">Mn</td> <td style="width: 25%;">Cr</td> <td style="width: 25%;">Ni</td> </tr> <tr> <td>0.09</td> <td>0.9</td> <td>6</td> <td>18</td> <td>8</td> </tr> </table>   | C              | Si                      | Mn                   | Cr                 | Ni                      | 0.09     | 0.9                | 6                       | 18       | 8   |    |    |     |
| C   | Si  | Mn             | Cr                      | Ni                   |                    |                         |          |                    |                         |          |     |    |    |     |
| 0.09  | 0.9   | 6              | 18                      | 8                    |                    |                         |          |                    |                         |          |     |    |    |     |
| PROPRIÉTÉS MÉCANIQUES                             | <table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <tr> <th rowspan="2">Heat Treatment</th> <th rowspan="2">R<sub>P0,2</sub> (MPa)</th> <th rowspan="2">R<sub>m</sub> (MPa)</th> <th rowspan="2">A<sub>5</sub> (%)</th> <th>Impact Energy (J) ISO-V</th> <th rowspan="2">Hardness</th> </tr> <tr> <th>-196°C</th> </tr> <tr> <td>As Welded</td> <td>400</td> <td>600</td> <td>40</td> <td>40</td> <td>HRC</td> </tr> </table> | Heat Treatment | R <sub>P0,2</sub> (MPa) | R <sub>m</sub> (MPa) | A <sub>5</sub> (%) | Impact Energy (J) ISO-V | Hardness | -196°C             | As Welded               | 400      | 600 | 40 | 40 | HRC |
| Heat Treatment                                    | R <sub>P0,2</sub> (MPa)   |                |                         |                      |                    | R <sub>m</sub> (MPa)    |          | A <sub>5</sub> (%) | Impact Energy (J) ISO-V | Hardness |     |    |    |     |
|   |   | -196°C         |                         |                      |                    |                         |          |                    |                         |          |     |    |    |     |
| As Welded   | 400   | 600            | 40                      | 40                   | HRC                |                         |          |                    |                         |          |     |    |    |     |
| ETUVAGE   | non nécessaire  |                |                         |                      |                    |                         |          |                    |                         |          |     |    |    |     |
| 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 |