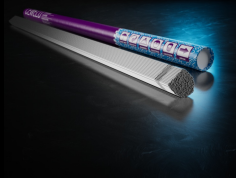


# CEWELD 307Si Tig

TYPE	Tig welding rod for dissimilar welding and buffer layers. (Type 18 8 Mn, 1.4370)																	
APPLICATIONS	CEWELD 307Si Tig 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 -110°C.																	
CLASSIFICATION	AWS	A 5.9: ~ER 307																
	EN ISO	14343-A: W 18 8 Mn																
	W.Nr.	1.4370																
	F-nr	6																
	FM	5																
SUITABLE FOR	<b>19% Cr / 9% Ni / 7% Mn, ISO 15608: 8.1 Cr ≤ 19 %</b> 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	CE																	
WELDING POSITIONS																		
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	<table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <thead> <tr> <th>C</th> <th>Si</th> <th>Mn</th> <th>Cr</th> <th>Ni</th> </tr> </thead> <tbody> <tr> <td>0.12</td> <td>0.9</td> <td>6</td> <td>18.5</td> <td>8.5</td> </tr> </tbody> </table>	C	Si	Mn	Cr	Ni	0.12	0.9	6	18.5	8.5							
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MECHANICAL PROPERTIES	<table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <thead> <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 colspan="2">Impact Energy (J) ISO-V</th> <th rowspan="2">Hardness</th> </tr> <tr> <th colspan="2">-196°C</th> </tr> </thead> <tbody> <tr> <td>As Welded</td> <td>420</td> <td>615</td> <td>40</td> <td colspan="2">45</td> <td>HRc</td> </tr> </tbody> </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	420	615	40	45		HRc	
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		-196°C																
As Welded	420	615	40	45		HRc												
REDRYING	Not required																	
GAS ACC. EN ISO 14175	I1																	



# CEWELD 307Si Tig

307SI TIG 1,0 X 1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663412225

307SI TIG 1,2 X 1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663412232

307SI TIG 1,6 X 1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663412249

307SI TIG 2,0 X 1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663412256

307SI TIG 2,4 X 1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663412263

307SI TIG 3,2 X 1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663412270

307SI TIG 4,0 X 1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663412287