



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