



CEWELD SA 307

TYPE Stainless steel 307 Type Solid wire for SAW dissimilar welding and buffer layers(1.4370)

APPLICATIONS CEWELD SA 307 for tough buffer layers before hardfacing, 14% manganese steels, 13 - 17% chromium and heat-resistant steels and mixed compounds. Rails, as a buffer layer on concrete crushers

PROPERTIES CEWELD SA 307 has a medium strength with very high resistance to cracking due to its high elongation. We recommend CEWELD FL 880 or FL 838 as welding flux

CLASSIFICATION

AWS	A 5.9: ER307
EN ISO	14343-A: S 18 8 Mn
W.Nr.	1.4370
F-nr	6
FM	5

SUITABLE FOR **19%Cr, 9%Ni Type, ISO 15608: 8.1 < 19%Cr, 1.4316**
 1.4306, 1.4301, 1.4541, 1.4550, 1.4311, 1.4546, 1.4312, 1.4300, 1.4312, 1.4371, 1.4541, 1.4543, 1.4550, 1.4452
 X2CrNi 19 11 (TP), X4CrNi 18 10 (TP), X6CrNiTi 18 10 (TP), X6CrNiNb 18 10 (TP), X2CrNiN 18 10 (TP), X5CrNiNb 18 10, G-X10CrNi 18 8 (TP)
 AISI 202, 302, 304L, 304, 305, 321, 347, 304 LN,
 ASTM A320 Grade B8C/D

APPROVALS CE

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

C	Si	Mn	P	S	Cr	Ni	Mo
0.1	0.5	4	0.02	0.02	20	9	1

MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V	Hardness
				RT	
As Welded	350	600	34	80	HRc

REDRYING Not required

GAS ACC. EN ISO 14175