

XP ER 307Si

STAINLESS STEEL



CLASSIFICATIONS

EN ISO 14343-A	AWS A5.9
W 18 8 Mn	~ER307

KEY FEATURES AND APPLICATIONS

- Solid wire often used for welding dissimilar steels, unalloyed steels, austenitic stainless steels, heat-resistant steels, hardening and tempering steels.
- Suitable for depositing stress relaxing buffer layers on crack sensitive base metals.
- Offers corrosion resistance comparable to type 304 stainless steel.
- Exceptional mechanical properties, crack resistance and work-hardening characteristics.
- Ideal for a variety of applications, including buffer layers before hardfacing, armour plate, exhaust systems, heterogeneous welding and difficult to weld steels.

BASE MATERIALS

X3CrNiMo17-13-3, X5CrNi18-10, X6CrNiMoTi17-12-2, X10CrNiMo 18-12

CHEMICAL COMPOSITION OF ALL-WELD METAL %

	C	Si	Mn	P	S	Cr	Ni	Mo	Cu
MIN	-	-	5.0	-	-	17.0	7.0	-	-
MAX	0.20	1.2	8.0	0.03	0.03	20.0	10.0	0.5	0.5

Single values are maximum values according to EN ISO 14343

MECHANICAL PROPERTIES OF ALL-WELD METAL - TYPICAL (MIN.) VALUES

Yield Strength (MPa)	Tensile Strength (MPa)	Elongation (%)	Impact ISO-V (J)
510 (≥350)	708 (≥500)	28 (≥25)	≥50

Test data for mechanical properties are not guaranteed since actual as welded conditions depend on numerous variables

OPERATING DATA

Shielding Gases	Polarity
EN ISO 14175 - I1	DC-

PACKAGING AND AVAILABLE SIZES

Part Number	Diameter (mm)	Length (mm)	Weight (kg)	Packaging
XP30304	1.6	1000	5	PAP 20 Tube
XP30306	2.4	1000	5	PAP 20 Tube
XP30308	3.2	1000	5	PAP 20 Tube