

MIG Wire for Welding of Austenitic Stainless Steels

Classification

AWS A5.9 : ~ ER307
ISO 14343-A : ~ G 18 8 Mn

General Description

Solid wire with 7% Mn for welding steels with difficult weldability such as armour plates and austenitic high Mn-steels.
Often used as a buffer layer in hardfacing applications.

Chemical Composition (w%), Typical, Wire

C	Si	Mn	Cr	Ni	P+S
0.08	0.80	7	19	9	< 0.035

Mechanical Properties, Typical, All Weld Metal

Yield Strength : 420 N/mm²
Tensile Strength : 620 N/mm²
Elongation (L=5d) : 40 %
Impact ISO-V : 80 J (+20°C)

Shielding Gases (acc. ISO 14175 and EN 439)

MIG : M13 - Ar + % 1.5 - 3 O₂
M12 - Ar + % 1 - 5 CO₂

Materials to be Welded

Various steel grades such as; armour plates, hardenable steels including steels difficult to weld, non-magnetic steels, work hardening austenitic manganese steels and dissimilar joints (CMn-steels to stainless steels).

Packaging and Available Sizes

Diameter	0.8	1.0	1.2	1.6	2.0	2.4	3.2	Spool Weight
MIG Wire	-	-	X	-	-	-	-	12.5 kg