

GETIG 307

IDENTIFICATION

Getig 307, ER 307

CLASSIFICATION

AWS /SFA 5.9: ER 307,
EN 14343 (EN 12072, G 18 8 Mn)

DESCRIPTION

The wire gives a strong, ductile and tough austenitic deposit which works-hardens from about 200HV to 450HV. Also compatible with cast iron in some applications. The addition of about 6% Mn gives good crack resistance in difficult highly restrained joints.

CHEMICAL ANALYSIS (RANGE) %

C	Mn	Si	Cr	Ni	Cu	Mo	S	P
0.04 - 0.14	3.30 - 4.75	0.30 - 0.65	19.5 - 22.0	8.0 - 10.70	0.75 max	0.5 - 1.50	0.03 max	0.03 max

MECHANICAL PROPERTIES (RANGE)

UTS (MPa)	EL (%)	CVN Impact Value	
590 min	39 min	Temp	Joules
		-50°C	95

TYPICAL APPLICATIONS

- Joining, repair and build up of 13% Mn (Hadfield) steel castings combinations of mild, harden able or stainless steels with little or no preheat.
- Use for mixed welding where deposits have to be heat treated and for surfacing and buttering.
- The most versatile and economic solid wires for dissimilar welds.

SHIELDING GAS : Ar + 2 % O₂ , Ar + 5-20% CO₂

WELDING MODE : =+

PACKING PARAMETERS

Size (mm)	Length (mm)	Packing / Pkt (kg)	Packing / Box (kg)
1.6	1000	5	5 x 4 = 20
2	1000	5	5 x 4 = 20
2.40 / 2.50	1000	5	5 x 4 = 20
3.15 / 3.20	1000	5	5 x 4 = 20