

# GM 307

## IDENTIFICATION

GM 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 work-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	3.5 - 4.75	0.3 - 0.65	19.5 - 22.0	8 - 10.7	0.3 max	0.3 max	0.03 max	0.03 max

## MECHANICAL PROPERTIES (RANGE)

UTS (MPa)	EL (%)	CVN Impact Value	
		Temp	Joules
590 min	30 min	-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 % O<sub>2</sub> , Ar + 5 - 20 % CO<sub>2</sub>

**WELDING MODE :** (=+)

## PACKING PARAMETERS

Size (mm)	Welding Parameters		Weight / Spool (kg)
	Pulsed arc (A)	(V)	
0.8	100 - 150	22 - 27	12.5 / 15.0
1	120 - 200	24 - 28	12.5 / 15.0
1.2	140 - 220	24 - 28	12.5 / 15.0
1.6	180 - 260	24 - 30	12.5 / 15.0