

Stainless solid wire

Classification

AWS A5.9 :ER 307*
 EN 12072 :W 18 8 Mn / G 18 8 Mn

* Nearest classification

General Description

Solid wire for welding steels with difficult weldability
Often used as a buffer layer in hardfacing applications

Shielding gases (acc. EN 439)

GTAW I1 Inert gas
 GMAW M12 Mixed gas Ar + > 0-5% CO₂
 GMAW M13 Mixed gas Ar + > 0-3% O₂

Approvals

	TÜV
GTAW	+
GMAW	+

Chemical composition (w%), typical, all weld metal

C	Mn	Si	Cr	Ni
0.08	7.1	0.8	19.2	9

Mechanical properties, all weld metal

		Process	Shielding gas	Condition	0.2% Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Elongation (%)	Impact (ISO), J	
								+20 °C	-120 °C
Required	EN12072	GTAW	I1	AW	400	650	34	100	50
Typical values after welding		GTAW	M12	AW	400	630	40	80	50

Materials to be welded

Various steel grades as:
 - Armour plate
 - Hardenable steels including steels difficult to weld
 - Non-magnetic steels
 - Work hardening austenitic manganese steels
 - Dissimilar joints (CMn-steels to stainless steels)

Packaging, available sizes and identification

Process	Unit:	Sizes, mm		
		1.0	1.2	2.0
GTAW	2 kg tube			X
GMAW	15 kg spool BS300	X	X	

Other sizes and packaging on request

Identification

Imprint: Revicor®307

Tip colour:

Revicor®307: rev.EN 20