

Solid wire for welding of stainless and heat resistant steels

Classification

AWS A5.9 :ER 307*
GOST 2246-70 : 08Cr20Ni9Mn7Ti

* Nearest classification

General Description

Stainless solid Cr-Ni wire for welding of austenitic stainless steels 03Cr18Ni11, 06Cr18Ni11, 08Cr18Ni10Ti, 12Cr18Ni10Ti, 304 etc. in an atmosphere of shielding gas Ar+(1-5%)CO₂ or Ar+(1-3%)CO₂.

Deposited metal has high corrosion resistance. Low content of carbon reduces the risk of intergranular corrosion, and provides smooth bead appearance.

Wire is applicable in food, petrochemical, machine building industries for production of pipe lines, tanks, boilers, etc.

Shielding gases (acc. EN 439)

GTAW I1 Inert gas

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

C	Mn	Si	Cr	Ni	Ti
0.08	7.2	0.75	20.5	9.5	0.75

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
Required	EN12072	GTAW	I1	AW	min 430	min 600	min 30	80
Typical values after welding		GTAW	I1	AW	470	640	35	95

Materials to be welded

DIN

Heat resisting steel

X5CrNi 18 9 1.4301

X2CrNi 18 9 1.4306

X10CrNiNb 18 9 1.4550

Packaging, available sizes and identification

Process	Unit:	Sizes, mm			
		0.8	1.0	1.2	1.6
GTAW	5 kg tube	X	X	X	X
GMAW	15 kg spool BS300	X	X	X	X

Other sizes and packaging on request

Identification Imprint: Revicor®307

Tip colour:

Revicor®307: rev.EN 20