

ROYAL –ER 307Si Stainless Steel Solid Filler Wire Rods

AWS/ SFA A 5.9 ER 307 Mod

Description

This wire rods content 18.5 Cr, 8.5 Ni, 6.0 Mn confirms to AWS – SFA 5.9 ER 307 class. The weld metal is very good crack resistant and free from porosity & molten pool.

Typical Applications

It is used for welding AISI, ASTM 308, 304, 304L type Stainless Steel plate, Sheets, Pipes, Tubes etc. it use for moderate strength weld with dissimilar steels austenitic manganese steel, carbon steel, forgings and castings.

Packing

Each Packets content 5 kg of Wire Rods having length 1000mm
Also available in MIG wire Size 0.80 , 1.00, 1.20, 1.60 mm in 12.5 kg Spool.

MIG TIG WIRES

Chemical Composition Of Weld Metal

C%	Mn%	Si%	S%	P%	Cr %	Ni %	Mo %
0.04 - 0.14	5.5– 7.5	1.00 Max	0.03 Max	0.03 Max	18.0 - 22.0	8.0– 10.0	1.0 Max

Mechanical Properties Of Weld Metal

U.T.S. (N/mm ²)	ELONGATION (L = 4d) %	Shielding Gas
650	35 % Min	Ar + 2% Oxygen