



TIG 307



Standards

AWS 5.9
ER 307

EN ISO 14343-A
W 18 8 Mn

W. Nr.
1.4370

Description & applications

Filler metal in solid wire sticks for TIG welding of austenitic or ferritic stainless steels. The high Manganese content of 307 reduces the risk of high temperature cracks. Recommended for the welding of high Manganese stainless steels. Also used for heterogenous welding in certain cases

Typical chemical composition (%)

C max	Mn	Si	Cr	Ni	Mo	S max	P Max	Fe
0.10	6.8	0.5	18.0	8.5	0.04	0.02	0.02	Base

Typical mechanical properties of all-weld metal

Rm	Rp 0,2	A5	KV-196°C
650 MPa	450 MPa	39 %	30 J

Operating parameters

Shielding gas recommendations :

EN ISO 14175 I1 : 100 %Argon 6 -12 l/mn Root : Argon, Nitrogen 3 – 6 l/mn



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