

Standards

TS EN ISO 14343-A	: G 18 8 Mn
EN ISO 14343-A	: G 18 8 Mn
TS EN ISO 14343-A	: W 18 8 Mn
EN ISO 14343-A	: W 18 8 Mn
AWS A5.9	: ~ER 307

**Chemical Composition of
Welding Wire % (Typical)**

C	Si	Mn	Cr	Ni
0.08	0.9	7.0	19.2	9.0

Mechanical Properties

Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Impact Strength (ISO-V/+20°C)	Elongation ((L ₀ =5d ₀) (%))
min. 370	580 - 750	min. 63 J	min. 30

Features and Applications

- Filler welding of high-strength low-alloyed and alloyed heat-treatable steels, armor steels, steels including 14 % Mn, ferritic chromium steels, heat-resistant steels, non-magnetic steels etc.
- Joint welding of different types of steels with each other
- Filler welding of abrasion-resistant steels for valves and turbines
- As shielding gas, Argon is used at TIG welding, where as Ar+ % 2.5 O₂ or Ar+ % 2.5 CO₂ mixed gas is used at MIG welding

Welding Positions

Current Type

MIG DC(+) / TIG DC(-)

Operating Data

Product Code	Diameter x Length (mm) / (inch)		Weight (Kg)	Package Type
6011100313	0,8	0.030"	12.5	BS 300
6011100381	1	0.040"	15	BS 300
6011100314	1,2	0.047"	15	BS 300
6011100312	1,6	0.062"	15	BS 300
6011100315	2,00 x 1000	5/64 x 39"	5	Plastic Box
6011100316	2,40 x 1000	3/32 x 39"	5	Plastic Box
6011100317	3,20 x 1000	1/8 x 39"	5	Plastic Box

Approvals: SEPRO, DB