

SW-307

DESCRIPTION & APPLICATION

Stainless Steel MIG/TIG Filler wire with a significant amount of Manganese, making the deposit fully Austenitic. Joining of Austenitic Stainless to Carbon Steels as well as 14% Manganese. Used to join Wear Plates and as a Buffer layer under hard surfacing. Fully Austenitic deposit, non-magnetic with high ductility.

BASE MATERIALS

All 300 series Austenitic Stainless Steels, 14% Manganese Steel, Railway and Crane Tracking, Wear Plates, Buffer layer on Manganese or high carbon/high manganese steel prior to hard facing.

MECHANICAL PROPERTIES

~650 UTS n/mm	~450 YIELD 0.2%	>38 ELONG A5%	120 IMPACT (J) 20°C
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METAL WELD COMPOSITION %

C	Si	Mn	Cr	Ni	Mo	S	P	Fe
0.15	0.95	6.5	19.5	9.0	0.3	0.02	0.025	BAL

PACKAGING

15kg Spools (MIG)
5kg Tubes (TIG)

DIAMETERS

0.8, 1.0, 1.2, 1.6mm (MIG)
1.6, 2.4, 3.2mm (TIG)

WELDING INSTRUCTIONS

Shielding gas 5% or 20% CO₂ in Argon, or 2% Argon-OxTIG. Do not allow the base material to overheat, particularly when welding Manganese Steel.