ES TIG 307

GTAW

18 8 Mn

ESWECO
The Art of Welding

Description

Bare, corrosion-resistant, chromium-nickel-manganese welding rods for welding austenitic stainless alloys of the 18% Cr, 8% Ni, 7% Mn types. ES TIG 307 has general corrosion resistance similar to that of the corresponding parent metal. The higher silicon content improves the welding properties such as wetting. When used for joining dissimilar materials, the corrosion resistance is of secondary importance. The alloy is used in a wide range of applications across the industry, such as the joining of austenitic, manganese, work-hardenable steels, as well as armour plate and heat-resistant steels.

Current

DC (-)

Classifications

EN 12072	W 18 8 Mn
Werkstoffnummer	appr. 1.4370

Typical all weld metal composition, %

C	Si	Mn	Cr	Ni
<0.2	<1.2	6.5	18.5	8.5

Typical mech. Properties all weld metal

Yield stress, MPa	450
Tensile strength, MPa	640
Elongation, %	41

Charpy V

Test temps, °C	Impact values, J
+20	130

Welding parameters

Diameter,mm	Length, mm	Weight of rods/box, kg
1.6	1000	5.0
2.0	1000	5.0
2.4	1000	5.0