
# CEWELD SA 307

certilas® THE FILLER METAL SPECIALIST

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|---|---|
| TYPE | Stainless steel 307 Type Solid wire for SAW dissimilar welding and buffer layers.(1.4370, 307, 18 8) |
| APPLICATIONS | CEWELD® SA 307 for tough buffer layers before hardfacing, 14% manganese steels, 13 - 17% chromium and heat-resistant steels and mixed compounds. Rails, as a buffer layer on concrete crushers |
| PROPERTIES | CEWELD® SA 307 has a medium strength with very high resistance to cracking due to its high elongation. We recommend CEWELD® FL 838 or FL 880 as welding flux |

CLASSIFICATION

| | |
|---|---|
| AWS | A 5.9: ~ER 307 |
| EN ISO | 14343-A: S 18 8 Mn |
| W.Nr. | 1.4370 |
| F-nr | 6 |
| FM | 5 |

SUITABLE FOR

**19%Cr, 9%Ni Type, ISO 15608: 8.1 , 1.4316**
1.4306, 1.4301, 1.4541, 1.4550, 1.4311, 1.4546, 1.4312, 1.4300, 1.4312, 1.4371, 1.4541, 1.4543, 1.4550, 1.4452
X2CrNi 19 11 (TP), X4CrNi 18 10 (TP), X6CrNiTi 18 10 (TP), X6CrNiNb 18 10 (TP), X2CrNiN 18 10 (TP), X5CrNiNb 18 10, G-X10CrNi 18 8 (TP)
AISI 202, 302, 304L, 304, 305, 321, 347, 304 LN,
ASTM A320 Grade B8C/D

APPROVALS: CE

WELDING POSITIONS


TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

| C | Si | Mn | P | S | Cr | Ni |
|---|---|---|---|---|---|---|
| 0.09 | 0.7 | 6.5 | 0.02 | 0.02 | 18 | 8 |

MECHANICAL PROPERTIES

| Heat Treatment | $R_{P0,2}$ (MPa) | Rm (MPa) | A5 (%) | Impact Energy (J) ISO-V | Hardness |
|---|---|---|---|---|---|
| | | | | RT | |
| As Welded | 400 | 600 | 34 | 80 | HRc |

REDRYING: Not required

GAS ACC. EN ISO 14175