

## TECHNICAL DATASHEET - WELDING CONSUMABLE

<b>AWS Code:</b>	-
<b>Product Code:</b>	RW 307
<b>Werkstoff No.:</b>	1.4370
<b>MIG Certification:</b>	-
<b>TIG Certification:</b>	-

### EQUIVALENT OF OTHER STANDARD

EN ISO 14343-A:2017 Nominal Composition	AWS A5.9:2017 Alloy Designation	EN ISO 14343-B:2017 Alloy Type	AWS A5.9:2017 Composition Designation
18 8 Mn	-	-	-

### DESCRIPTION AND APPLICATIONS

RW 307 / RW 307L / RW 307SI is a fully austenitic stainless welding wire class for manganese steels, armor steels and dissimilar carbon or low-alloy steels. Used for buffer layers and buttering before hard-facing when a ductile weld metal with high hot-cracking resistance is required. RW 307L is preferred when a lower carbon level is needed compared with RW 307. RW 307SI uses higher Si content to improve weld-pool fluidity and reduce spatter.

### TYPICAL CHEMICAL COMPOSITION (%)

	Min.	Max.
<b>C</b>	-	0,08
<b>Mn</b>	5,00	8,00
<b>Si</b>	-	0,50
<b>S</b>	-	0,030
<b>P</b>	-	0,030
<b>Cr</b>	17,0	20,0
<b>Ni</b>	7,0	10,0
<b>Mo</b>	-	0,30
<b>Cu</b>	-	0,30
<b>N</b>	-	-
<b>Nb</b>	-	-
<b>Ti</b>	-	-

### DIAMETER

<b>MIG sizes</b>	0,8   0,9   1,0   1,14   1,2   1,6
<b>TIG sizes</b>	0,8   0,9   1,0   1,2   1,6   2,0   2,4   3,2   4,0
<b>SAW sizes</b>	1,6   2,0   2,4   3,2   4,0

### PACKAGING

<b>MIG</b>	Blue Metallic Wire Basket BS300: 15 Kg. Plastic Spool D300: 15 Kg. Plastic Spool D200: 5 Kg. Wooden/Metallic Bulk Spool: 250 Kg. Drum: 250-400 Kg.
<b>TIG</b>	Carton Boxes/Tubes: 5 Kg. (1000 mm Rod Length)
<b>SAW</b>	Metallic Wire Basket K415 Wooden/Metallic Bulk Spool: 250 Kg. Drum: 300 Kg.

Note: Safety Data Sheet is available on request.

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<b>AWS Code:</b>	-
<b>Product Code:</b>	RW 307SI
<b>Werkstoff No.:</b>	1.4370
<b>MIG Certification:</b>	TUV (0,8-1,6 mm) - CE - UKCA - DB
<b>TIG Certification:</b>	-

### EQUIVALENT OF OTHER STANDARD

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18 8 Mn	-	-	-

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### EXPECTED MINIMUM MECHANICAL PROPERTIES AS WELDED

	MIG	TIG	SAW
<b>Rp0,2 [MPa]</b>	450	-	-
<b>Rp1 [MPa]</b>	470	-	-
<b>Rm [MPa]</b>	640	-	-
<b>A [%]</b>	40	-	-
<b>Z [%]</b>	60	-	-
<b>Impact Energy, ISO-V 20°C</b>	167	-	-
<b>Impact Energy, ISO-V -20°C</b>	-	-	-
<b>Impact Energy, ISO-V -60°C</b>	-	-	-
<b>Impact Energy, ISO-V -110°C</b>	-	-	-
<b>Impact Energy, ISO-V -120°C</b>	51	-	-
<b>Impact Energy, ISO-V -196°C</b>	-	-	-

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<b>SAW sizes</b>	1,6   2,0   2,4   3,2   4,0

### TYPICAL CHEMICAL COMPOSITION (%)

	Min.	Max.
<b>C</b>	-	0,10
<b>Mn</b>	5,00	8,00
<b>Si</b>	0,65	1,00
<b>S</b>	-	0,030
<b>P</b>	-	0,030
<b>Cr</b>	17,0	20,0
<b>Ni</b>	7,0	10,0
<b>Mo</b>	-	0,30
<b>Cu</b>	-	0,30
<b>N</b>	-	-
<b>Nb</b>	-	-
<b>Ti</b>	-	-

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