



MIG 18/8MN

Old reference: MIG 307

Classification

ISO 14343-A : G 18 8 Mn
 AWS A5.9 : ~ER307

Material N° : 1.4370

Description & Applications

Solid wire for joining and overlaying on manganese steel, high sulphur and phosphorus containing steels. Also used for joining dissimilar steels, construction steels to stainless steels... Also used for cushion layers prior hardfacing, for repairing of pieces submitted to shocks or wear.

Main applications: Civil engineering...

Typical Chemical Composition (%)

C	Si	Mn	Cr	Ni	Mo	Cu	P	S	Fe
0.09	0.9	7.0	19.0	8.5	0.1	0.08	<0.02	<0.01	Rem.

All Weld Metal Mechanical Properties

R _{p0.2} (MPa)	R _m (MPa)	A ₅ (%)	KV (J)
460	650	40	+20°C 140

Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters		Shielding Gas
		Pulsed arc (A)	(V)	
MIG = +	0.8	100-150	22-27	Ar + 2%CO ₂ Ar + 1%O ₂ 18-20 l/min
	1.0	120-200	24-28	
	1.2	140-220	24-28	
	1.6	180-260	24-30	

Ind.10



Liability: This document is intended to assist the user in choosing the product. It is up to the user to verify that the chosen product is suitable for applications for which it is intended. The company FSH Welding Group reserves the right to alter specifications without prior notice of its products. The descriptions, illustrations and specifications are for reference only and cannot be held liable for FSH Welding Group. **Fumes:** Consult information on MSDS, available upon request.