



TIG 18/8MN

Old reference: TIG 307Si

Classification

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

Material.N° : 1.4370

Description & Applications

Solid rod for TIG welding and overlaying on manganese steel, high sulphur and phosphorus contain steels. Also used for joining dissimilar steels as construction steels to stainless steels, as well as for cushion layers prior hardfacing, for repairing of pieces submitted to shocks or wear.

Main applications: Civil engineering, cimenteries...

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)
450	650	40	+20°C 120

Welding Current & Instructions

Welding mode	Shielding Gas
TIG = -	Ar : 6-12 l/min Back shielding : Argon / Nitrogen : 3-6 l/min

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