

# M-307Si

For austenite stainless steel (18%Cr-8%Ni STS)

## Classifications

EN ISO 14343-A:2009 : G 18 8 Mn

## Description

- MIG welding of 18%Cr-8%Ni-7%Mn austenite stainless steels
- It is used for dissimilar steel such as austenitic manganese steel to carbon steel forgings

## Welding positions



## Polarity & shielding gas

- DCEP (DC+)
- Ar + 1-3% O<sub>2</sub> (15 – 25 l/min)
- Ar + 1-5% CO<sub>2</sub> (15 – 25 l/min)

## Typical chemical composition of all-weld metal (%)

C	Si	Mn	Ni	Cr
0.07	0.64	6.79	8.91	18.79

## Typical mechanical properties of all-weld metal

	Yield Strength	Tensile Strength	Elongation	Impact Value (J)	
	(MPa)	(MPa)	(%)	0 °C	-40 °C
EN ISO 14343	Min. 350	Min. 590	Min. 25		
Example	436	619	42	111	77