



GMAW / GTAW STAINLESS STEEL
MIGINOX 307

18 8 Mn TYPE STAINLESS STEEL SOLID WIRE



CLASSIFICATION : EN ISO 14343-A

G 18 8 Mn

KEY FEATURES :

- 18-8-Mn type stainless steel solid wire
- Smooth operating characteristics
- Good crack resistance
- High work hardening characteristics
- Non magnetic weld deposit

WELDING POSITION :



DCEP

Shielding Gas	Gas Flow Rate, LPM	Stickout, mm
98Ar/2O ₂	15-22	10-20

TYPICAL APPLICATIONS :

- Suitable for austenitic manganese steels and dissimilar metal welding
- Welding of manganese steels to carbon steels castings or forgings

STORAGE / HANDLING :

Keep dry and follow handling instructions mentioned on the box

CHEMICAL COMPOSITION OF BARE SOLID WIRE, Wt% :

	C	Mn	Si	Cr	Ni
Specification	0.20 max	5.0-8.0	1.20 max	17.0-20.0	7.0-10.0
	Mo	Cu	S	P	
Specification	0.50 max	0.50 max	0.03 max	0.03 max	

MECHANICAL PROPERTIES OF ALL WELD METAL :

	Condition	UTS, MPa	YS at 0.2% offset, MPa	EL%
Specification	As Welded	500 min	350 min	25 min

PACKING DATA :

Ø, mm	Kg/Spool
1.0	12.5
1.2	12.5
1.6	12.5