

INERTFIL 307

MIG-MAG Wires Stainless and Heat resistant steels

Inertfil 307 stainless steel solid wire is suitable for welding dissimilar steels, hardening and tempering steels, 13% Mn steels, Cr steels and ballistic steels. Good mechanical properties and wear resistance. Used for buffer layers.

| Classification | |
|----------------|-----------------------|
| AWS | A5.9: ER 307 (approx) |
| EN | 12072: G 18 8Mn |

| Approvals | Grades |
|-----------|--------|
| DB | |
| TÜV | |

see Appendix, Classification Society Approvals, for details pag. 521

Analysis of all-weld metal (Typical values in %)

| C | Mn | Si | P | S | Cr | Ni | Mo | Nb | Cu | N | Ferrite |
|------|----|------|---------|---------|----|----|----|----|----|---|---------|
| 0.10 | 7 | 0.80 | ≤ 0.030 | ≤ 0.030 | 19 | 9 | - | - | - | - | ≤ 5 |

All-weld metal Mechanical Properties

| Heat Treatment | Yield Strength N/mm ² | Tensile Strength N/mm ² | Elongation A5 (%) | Impact Energy ISO - V (J) 20°C | Hardness |
|----------------|-------------------------------------|---------------------------------------|----------------------|--------------------------------------|----------|
| As Welded | ≥ 420 | ≥ 590 | ≥ 30 | ≥ 50 | - |

Gas test: Acc. To EN 439: M13(Cargal1)

Shielding Gas: Acc. To EN 439: M13(Cargal1)

Materials

Armour plate; Dissimilar Steels
X120Mn12 (1.3401)

Storage

Keep dry and avoid condensation

Current condition and welding position

DC+



Packaging data: BS300 Kg. 15

| Diameters | 0,8 | 1,0 | 1,2 | | | |
|-----------|-----|-----|-----|--|--|--|
| | | | | | | |