

INERTROD 307

TIG Rods Stainless and Heat resistant steels

Inertrod 307 is a stainless TIG rod suitable for welding dissimilar steels, hardening and tempering steels, 13% Mn steels, Cr steels and ballistic steels. Good mechanical properties and wear resistance. Inertrod 307 is also used for buffer layers.

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

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: I1(Arcal1)

Shielding Gas: Acc. To EN 439: I1(Arcal1)








Materials

Armour plate; Dissimilar Steels
X120Mn12 (1.3401); 1.4370

Storage

Keep dry and avoid condensation

Current condition and welding position

DC-						
						
PA	PB	PC	PG	PF	PE	PF2

Packaging data: Tube 5 kg

Diameters (L: 1000 mm)	2,4					
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Further forms of delivery on request.