

KM-307Si

Classification

Shielding Gas: Ar+1~2%O₂
Ar+1~2%CO₂

AWS A5.9/A5.9M ER307 (near equiv.)
ISO 14343 A G 18 8 Mn

Applications and Features

- (1) Weld metal is 20%Cr-9%Ni-6%Mn.
- (2) Good crack resistance.
- (4) It is suitable for welding thick plates, rigid joints, dissimilar metals (carbon steel and stainless steel), high manganese steel and armour steel.

Welding Instruction

- (1) Use Ar blend with 1~2%O₂ for high current spray transfer welding.
- (2) Use Ar blend with 1~2%CO₂ for low current, short-circuit transfer welding.

Typical Chemical Composition of Wire (wt%)

C	Si	Mn	P	S	Cr	Ni
0.060	0.82	6.10	0.018	0.012	19.22	8.10

Typical Mechanical Properties of Weld Metal (Shielding Gas : Ar+2% O₂)

Tensile Strength MPa	Yield Strength MPa	Elongation %
610	460	41

Size and Suggested Operating Range (DC+)

Shielding Gas		Diameter (mm)		
		1.0	1.2	1.6
Ar+1~2%CO ₂	Amp	80-160	100~210	—
	Volt	16-22	17~22	—
Ar+1~2%O ₂	Amp	180-280	200~300	220~330
	Volt	22-28	24~30	24~32

Diam.	15 kg Spool
1.2mm	KM3071215
1.6mm	KM3071615

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