



# FILINOX 307 Si

SARMA PLINA PENTRU OTELURI INOXIDABILE / SOLID WIRE FOR STAINLESS STEEL

## CLASIFICARE / STANDARDS

EN 12072-99 : G 18 8 Mn  
AWS A5.9-93 : ER 307

## AUTORIZARI / APPROVALS

TÜV : SG-X 15 Cr Ni Mn 18 8

## CARACTERISTICI PRINCIPALE

Sarma plina aliata cu Ni-CR-Mn, destinate sudarii MIG a otelurilor de tip AISI 307, a realizarii imbinarilor intre oteluri carbon si oteluri inox sau a otelurilor austenitice manganoase. Poate fi folosita de asemenea pentru sudarea otelurilor greu sudabile, a otelurilor cu un procent de 13% Mn, si a altor tipuri de oteluri. Este de asemenea recomandata si pentru realizarea primelor straturi in cazul incarcilor. Metalul depus este pur austenitic, cu o mare rezistenta la abraziune. Se recomanda a se utiliza in amestec de gaz (Ar/1-2%O<sub>2</sub>).

## MAIN FEATURES

Solid wire Ni-Cr-Mn alloyed for MIG welding of AISI 307, for carbon steels with stainless steels, and austenitic manganese steels. Also suitable for welding hard steels, 13% Mn steels, armour and ballistic steels. It can be used for the first layer before the cladding. Pure austenitic bead with very good resistance to abrasion. To be used with Ar/1-2% O<sub>2</sub> shielding gas.

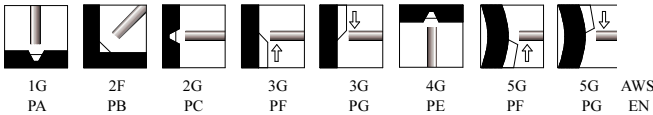
## DOMENII DE APLICATIE

Recipienti (inclusiv industria chimica si petrochimica)  
Industria constructoare de masini  
Incarcari/ Placari  
Sudarea otelurilor placate

## MAIN APPLICATIONS

Vessels, boilers fabrication (including the chemical petrochemical industry)  
Industrial machinery construction  
Hardfacing/cladding  
Welding of armour steels

## POZITII DE SUDARE / WELDING POSITIONS



CURRENT / CURRENT : DC+

GAZ : Ar/ 2%O<sub>2</sub>  
: (M13) EN 439

## ANALIZA CHIMICA A SARMEI % / ALL - WELD METAL CHEMICAL ANALYSIS %

C	Mn	Si	S	P	Cr	Ni	Mo		
0.07-0.10	6.50 - 7.00	0.65 - 0.90	≤ 0.03	≤ 0.03	18.50 -19.50	8.00 - 9.00	≤ 0.50		

## CARACTERISTICI MECANICE / MECHANICAL PROPERTIES

GAS	Trat. termic/Heat treatment	Rm N/mm <sup>2</sup>	Rp 0.2 N/mm <sup>2</sup>	E % 5d	Kv J +20°C
Ar/2%O <sub>2</sub>	Stare sudata/As welded	600	≥ 420	≥30	≥ 47

## AMBALARE / STANDARD PACKAGING

Ambalare/ Packaging	Greutate/ Weight(Kg)	Diametru mm/Diameter mm			
		0.8	1.0	1.2	1.6
D 300	12.5	2610947			
D 300	15		2610954	2610962	2610970

Datele mentionate pot fi modificate fara o notificare prealabila / The above data may change without prior notice.

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