

INERTFIL 307 is a G 18 8 Mn/ER 307 (similar) type solid MAG welding wire, supplied precision layer wound, depositing a C-18Cr8Ni6Mn weld metal. Suitable for use with Ar+2%O<sub>2</sub> or Ar+0.5...5%CO<sub>2</sub> mixed shielding gases.

INERTFIL 307 is suitable for welding dissimilar steels between unalloyed steels, austenitic stainless steels or heat resisting steels, also used for welding of hardening and tempering steels, such as ballistic steels.

The increased silicon content promotes weld pool fluidity to give a smooth deposit appearance.

Stainless steel wire for welding dissimilar steels, hardening and tempering steels, armored, bullet-proof and 13% Mn steels.

Classification		Approvals	Grade
EN ISO	14343-A: G 18 8 Mn	DB	●
AWS	A5.9: ER 307 (approx)	TÜV	●

### Chemical analysis (Typical values in %)

C	Mn	Si	P	S	Cr	Ni
0.10	7	0.8	≤ 0.030	≤ 0.025	19	9

### All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation A5 (%)	Impact Energy ISO - V (J)	
				+20 °C	-120 °C
As Welded	≥420	≥590	≥40	≥100	>32

Gas test: 98% Ar+2% CO<sub>2</sub>

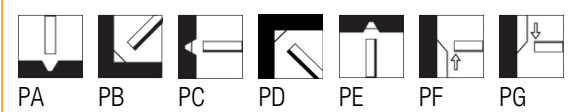
**Shielding Gas** - EN ISO 14175 : M12, M13

### Materials

Aciers difficilement soudables

Soudage hétérogènes aciers avec aciers Inoxydables

X120Mn12 (1.3401); Aciers de Blindage

Storage	Current condition and welding position
Keep dry and avoid condensation	DC+
	

### Packaging data

Packaging Type	BS300
Diam(mm) / weight(kg)	15
1.0	W000283110