

**AFROX MIG 307**



Afrox MIG 307 is a bright drawn, stainless steel welding wire suitable for the joining of armour plate, austenitic manganese steels, ferritic chromium stainless steels and dissimilar steels. The wire is also suitable for buffer layering prior to hardfacing. The weld deposit is work hardenable and heat resistant up to 850°C.

**CLASSIFICATIONS**

DIN 8556 SG X 15 CrNiMn 18 8

**CHEMICAL ANALYSIS**

% Carbon	0.20 max.
% Manganese	5.0 - 8.0
% Silicon	1.50 max.
% Chromium	17.0 - 20.0
% Nickel	7.0 - 10.0
% Sulphur	0.025 max.
% Phosphorus	0.035 max.

**TYPICAL MECHANICAL PROPERTIES  
ALL WELD METAL**

0.2% Proof Stress	390 MPa
Tensile Strength	590 - 740 MPa
Elongation on 4d	30% min.
Charpy V-Notch at +20°C	60J min

**Microstructure**  
Fully austenitic.

**PACKING DATA**

Diameter (mm)	Item Number
1.0	033-244
1.2	033-242

Suggested Shielding Gas: *Stainshield, Stainshield Plus, Argoshield 62, Helishield 101.*

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