

**SUBARC 307Si**



For use of dissimilar combinations of CMn, stainless, hardenable, wear-resistant and armour steels. Also suitable for 13% Mn manganese (Hadfield) steel and mixed welding applications. Can be used as buffer layers and a surfacing consumable.

**CLASSIFICATIONS**

AWS	A5.9	Similar to ER307
BS	EN 12072	18 8 Mn Si
DIN	8556	SG-X 15 CrNiMn 18 8 (1.4370)

**CHEMICAL ANALYSIS**

% Carbon	0.08	% Chromium	19.0
% Manganese	6.00	% Nickel	8.50
% Silicon	0.80	% Molybdenum	0.20
% Sulphur	0.01	% Copper	0.10
% Phosphorus	0.015		

**TYPICAL MECHANICAL PROPERTIES  
ALL WELD METAL**

Tensile Strength	640 MPa
0.2% Proof Stress	430 MPa
Elongation on 4d	36%
Charpy V-Notch at 20°C	110J

\* Flux Dependant

**PACKING DATA**

SAW Wire (DC+)

Diameter (mm)	Current		Item Number	Pack Mass (Kg)
	Amps	Volts		
3.20	350	32	078-140	25

Suggested flux : Afrox Flux MH or DX-9

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