Changzhou Giant Welding Co.,Ltd
www.giantweld.com

Standard：AWS A 5.9 YB/T5092	Chemical Composition %								
	C	Mn	Si	Cr	Ni	P	S	Mo	Cu
Grade ER307Si	0.04–0.14	6.5– 8.0	0.65 – 1.00	18.5– 22	8– 10.75	≤0.03	≤0.03	≤0.75	≤0.75

Type	Spool　(MIG)	Tube　(TIG)
Specification（MM）	0.8、0.9、1.0、1.2、1.6、2.0	1.6、2.0、2.4、3.2、4.0、5.0
Package	S100/1kg　　　　S200/5kg S270,S300/15kg-20kg	5kg/box　　10kg/box　　length :1000MM

Mechanical Properties	Tensile Strength　Mpa	Elongation after fracture　A（%）
	≥ 590	≥ 35

Diameter（MM）	0.8	1.0	1.2	1.6	2.0	2.5	3.2
Current　（A）	70～150	100～200	140～220	50～100	100～200	200～300	300～400

Application	ER307Si welding wire, also known as H09Cr21Ni9Mn4Mo. it is a kind of austenitic stainless steel MIGG TIG welding wire. The weld metal has good ductility and crack resistance and low crack sensitivity due to its high manganese content. It is suitable for non-magnetic steel, high manganese steel and so on. It is used for welding of high strength steel, different kinds of steel, such as H617 steel.
Notice	1. Oil, dirt and rust on the welding wire surface should be removed before welding. Surface impurities such as oil, rust and water should be thoroughly removed in the welding place, so as to prevent blowhole, crack and so on during welding. The surface around 10mm of the groove and its surroundings should be polished with metallic gloss. 2. In order to obtain good mechanical properties of welding seam, suggest protect gas Ar+2%O2. 3. In the welding process, the welding line energy directly affects the mechanical properties and crack resistance of weld metal, and should be paid more attention to. 4. The above welding methods, conditions and specifications are for reference only. Users should evaluate the welding process according to their own welding characteristics before using the welding wire for the formal product welding.

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