

RAAJ ER307

Stainless steel continuous & cut length solid welding wire for MIG/TIG welding

CLASSIFICATION : AWS/SFA-5.9 ~ER307; EN ISO 14343 18 8 Mn

CHARACTERISTICS : ER307 is Manganese-austenitic Stainless steel grade is suitable where high standards of toughness and cracks resistant have to specially meet. It is suitable for MIG/TIG/SA welding. The high silicon grade gives improved weld flow and weldability for smoother weld beads.

APPLICATION : ER307 suitable welding for cladding of hardenable steels, armour plate, austenitic stainless, manganese wear steels and heat resisting steels upto 850°C. The grade is particularly suitable for hard facing hot work steel, stainless valve steel and carbon steel items that must possess abrasion resistance to corrosion.

SHIELDING GAS : welding with 100% Ar gas and/or Ar+1-5% O₂ gas

CHEMICAL COMPOSITION % (solid wire chemistry)

C	Mn	Si	S	P	Ni	Cr	Cu	Mo
0.20	5.0 - 8.0	0.30 - 0.65	0.03	0.03	7.0 - 10.0	17.0 – 20.0	0.75	1.50

(single value maximum)

Typical All Weld Mechanical Properties (under Ar gas shield)

UTS (N/mm ²)	Yield strength (N/mm ²)	ELONGATION %
640	400	38

DIEMENSION, CURRENT CONDITION & PACKING DATA (RAAJMIG ER307)

Size (mm)	Size (inch)	Current Condition (DC+)	Voltage (V)	Gas Flow Rate L/min.	Spool packing 12.5 kg.	Spool packing 15 kg	Drum packing 100/200kg
0.80	0.030	70-220	16-24	10-20	√	√	X
1.00	0.040	100-250	20-24	10-20	√	√	√
1.20	0.047	150-300	24-34	15-25	√	√	√
1.60	0.062	150-350	28-36	15-30	√	√	√

DIEMENSION, CURRENT CONDITION & PACKING DATA (RAAJTIG ER307)

Size (mm)	Size (inch)	Length (mm)	Length (inch)	Current Condition (DC+)	Voltage (V)	Tube packing 5 kg	Box packing 20 kg
1.60	1/16"	1000	36"	80-110	10-16	√	√
2.00	5/64"	1000	36"	100-150	12-18	√	√
2.40 / 2.50	3/32"	1000	36"	130-180	14-20	√	√
3.20	1/8"	1000	36"	150-220	16-24	√	√
4.0	5/32"	1000	36"	200-280	18-28	√	√

Raajratna offer a wide range of Stainless steel welding wires for MIG/TIG/SA welding.

And also available RAAJMIG ER307Si version for MIG welding process

Tailor made packing on request.