

greenTECH NMS 307

ISO OERLIKON AG Schweisstechnik
CH-5737 Menziken AG – Tel. +41 (0)62 771 83 05
E-Mail info@iso-oerlikon.ch – www.iso-oerlikon.ch

Comparable specifications

ASME SFA A 5.9: ~ER307
EN ISO 14343-A: 18 8 Mn
Werkstoff Nr.: 1.4370

Description and applications*

* Illustrative, not-exhaustive list

Austenitic stainless steel filler metal with a significant amount of manganese, making the all-weld metal in most cases fully austenitic. It is a non-magnetic metal, with high ductility.

This grade may be used for:

- moderate-strength welds with good crack resistance between dissimilar steels such as austenitic manganese steel and carbon steel forgings or castings;
- joining of austenitic stainless to carbon steels;
- joining of wear plates;
- applications as a buffer layer under cladding.

Weldable base materials*

* Illustrative, not-exhaustive list

High carbon / high manganese steels

All-weld metal mech. properties*

* For reference only values

Tensile strength (Rm): ≥ 500 N/mm²
Elongation: $\geq 25\%$

Yield Strength (Rp_{0.2}): ≥ 350 N/mm²
Charpy-V Impact (R.T.): ≥ 50 J

Chemical composition*

* For reference only values

C	Mn	Si	S	P	Ni	Cr	Mo	Cu
max	5.00	max	max	max	7.00	17.00	max	max
0.20	8.00	0.65	0.030	0.030	10.00	20.00	0.50	0.50

Standard packaging data*

Welding process	Product type	Ø mm (inches)	Packing type	Weight kg (lbs)	Length mm (inches)
GMAW **	filler wire	0.80 - 1.20 (0.030 - 0.047)	spools BS300 / D300	15 (33)	n.a.
GTAW **	filler rod	1.60 - 4.00 (1/16 - 5/32)	cardboard boxes / tubes	5 (11)	1000 (39.4)
SAW **	filler wire	1.60 - 4.00 (1/16 - 5/32)	basket rims B450	25 (55)	n.a.
SMAW **	core wire for electrodes	1.60 - 5.00 (1/16 - 0.197)	wooden boxes	500 - 750 (1100 - 1650)	250 - 450 (10 - 18)

* Other sizes and packing types are available upon request

** GMAW: gas metal arc welding; GTAW: gas tungsten arc welding; SAW: submerged arc welding; SMAW: shielded metal arc welding

Marking

Each filler rod for GTAW welding is durably marked with an identification traceable to the unique product type. Welding filler materials wound on spools or in coils are durably marked on the coil or spool with an identification traceable to the unique product type.

The outside of each unit package is suitably labelled with at minimum the following data: grade, diameter, heat, lot no., classifications.

 marking type-testing performed and available.

Customized labels are available upon request.

Type approvals

DB Zulassungs nr. 43.097.02 (GMAW / GTAW)

TUV Nord Kennblatt nr. 04032 (GMAW) TUV Nord Kennblatt nr. 04033 (GTAW)

Lot classification

All our productions fulfil the **Class S3** requirements acc. to EN ISO 14344.