

FILINOX 307

SARMA PLINA PENTRU OTELURI INOXIDABILE /
SOLID WIRE FOR STAINLESS STEEL



CLASIFICARE / STANDARDS

AWS A5.9-93: ER 307
EN ISO 14343-A: G 18 8 Mn

AUTORIZARI / APPROVALS

DB: 43.116.05

CARACTERISTICI PRINCIPALE

Sarma plina aliata cu Ni-CR-Mn, destinate sudarii MIG a otelurilor de tip AISI 307, a realizarii imbinarilor intre oteluri carbon si oteluri inox sau a otelurilor austenitice manganoase. Poate fi folosita de asemenea pentru sudarea otelurilor greu sudabile, a otelurilor cu un procent de 13% Mn, si a altor tipuri de oteluri. Este de asemenea recomandata si pentru realizarea primelor straturi in cazul incarcarii. Metalul depus este pur austenitic, cu o mare rezistenta la abraziune. Se recomanda a se utiliza in amestec de gaz (Ar/1-2%O₂).

MAIN FEATURES

Solid wire Ni-Cr-Mn alloyed for MIG welding of AISI 307, for carbon steels with stainless steels, and austenitic manganese steels. Also suitable for welding hard steels, 13% Mn steels, armour and ballistic steels. It can be used for the first layer before the cladding. Pure austenitic bead with very good resistance to abrasion. To be used with Ar/1-2% O₂ shielding gas.

DOMENII DE APLICATIE

Recipienti (inclusiv industria chimica si petrochimica);
Industria constructoare de masini;
Incarcari/Placari;
Sudarea otelurilor placate.

MAIN APPLICATIONS

Vessels, boilers fabrication (including the chemical petrochemical industry);
Industrial machinery construction;
Hardfacing/cladding;
Welding of armour steels.

POZITII DE SUDARE / WELDING POSITIONS



1G PA 2F PB 2G PC 3G PF 3G PG 4G PE 5G PF 5G PG AWS EN

CURRENT / CURRENT: DC+

GAZ / GAS: Ar/ 2%O₂
(M13) EN 439

ANALIZA CHIMICA A SARMEI % / WIRE CHEMICAL ANALYSIS %

C	Mn	Si	S	P	Cr	Ni	Mo	Cu
0.07 - 0.12	5.10 - 8.00	0.65 - 0.90	≤ 0.03	≤ 0.03	17.00 - 20.00	7.00 - 10.00	≤ 0.50	≤ 0.30

CARACTERISTICI MECANICE / MECHANICAL PROPERTIES

GAZ	Tratament termic/Heat treatment	Rm N/mm ²	Rp 0.2 N/mm ²	E % 5d	Kv J +20°C	Kv J -20°C
Ar/2%O ₂	Stare sudată/As welded	≥ 600	≥ 420	≥ 30	≥ 50	≥ 40

AMBALARE STANDARD / STANDARD PACKING

Ambalare / Packaging	Greutate / Weight	Diametru mm / Diameter mm					
		1.0	1.2				
BS 300	15 kg	W000283112	W000283113				

Datele mentionate pot fi modificate fara o notificare prealabila. / The above data may change without prior notice.