

# Lincoln® MIG 307Si

## Key Features

- High silicon level for increased puddle fluidity, better bead shape and edge wetting
- Versatile wire for welding difficult to weld steels
- Precision layer wound wire assists feeding and resists wire tangles

## Conformances

**AWS A5.9/A5.9M:** ER307Si\*

**AS/NZS 14343-A:** G 18 8 Mn

\*nearest classification

## Typical Applications

- Suitable for welding steels with difficult weldability e.g. armour plate, austenitic manganese steels, dissimilar steels
- Good as a buffer layer in hardfacing applications

## Welding Positions



## Shielding Gas

- 98-99% Argon / 1-2 % O<sub>2</sub> (spray transfer)
- 98-99% Argon / 1-2% CO<sub>2</sub> (short circuit)
- Flow Rate: 15-20 L/min

## Diameter / Packaging / Settings

Diameter mm	Part Number	Packaging	WFS ipm	Voltage volts	Current amps	CTWD mm
1.2	331072	Spool S300 15kg	125-360	17-30	100-300	15-20
1.2	331073	Drum 250kg	125-360	17-30	100-300	15-20

## Mechanical Properties - As required per AWS A5.9

	Yield Strength MPa	Tensile Strength MPa	Elongation %	Charpy V-Notch J @ -50°C
<b>Requirements - AWS ER307Si</b>	Not specified	Not specified	Not specified	Not specified
<b>Typical Results</b>	460	610	40	50

## Wire Composition

	%C	%Mn	%Si	%Cr	%Ni
<b>Typical Results</b>	0.06	6.1	0.8	19.2	8.1