



HILCO HILCHROME G307

MAG wires – stainless steel – special purpose

AWS A5.9: ~ER 307

EN ISO 14343-A: G 18 8 Mn

Werkstoffnr. 1.4370

Wire type:
MAG Solid wire

Current:



Welding positions:



Shielding gas:

M12, M13, M21

Hilchrome G307 is our solid wire for MAG welding dissimilar steels and difficult-to-weld steels. Typical applications include joining 14Mn steels, spring steels, tool steels, and high carbon steels. Hilchrome G307 is recommended for buffer layers prior to surfacing. The deposit weld metal features strain hardenability, excellent cavitation resistance, thermal shock resistance and scaling resistance up to 850°C.

Base materials to be welded:

- Armour plate
- Hardenable steels incl. DFTW-steels
- Non-magnetic austenitic steels
- Work hardening austenitic manganese steels
- Heat resisting ferritic chromium steels
- Dissimilar joining

Applications:

- Repair & Maintenance
- Transport & Lifting Industry
- Process Industry

Chemical composition, wt.% weld metal – typical:

C	Mn	Si	Cr	Ni
0,08	7,00	0,80	19,00	9,00

Mechanical properties, weld metal – typical:

Condition	0,2% Yield strength MPa	Tensile strength MPa	Elongation Lo=5d - %	Impact Values ISO-V J
As welded	370	600	35	20°C ≥ 100

Note: properties under M13

Packaging and welding data:

Dia. mm.	Spool type	Weight / spool kg.
1,2	BS300	15