



# WB307MSi M.I.G. WELDING WIRE

**Classifications** BSEN 12072 : 18 8 Mn

**Product Description** 307 stainless steel, solid MIG wire.

**Applications** WB307MSi finds use in the joining, repairing and build-up of 13%Mn (Hadfield) steel castings.

In addition can be used on mild, hardenable or stainless steels with little or no preheat.

**Wire Composition (Weight %)**

	C	Mn	Si	S	P	Cr	Ni	Mo	Cu
<b>min.</b>	0.04	5.5	0.30	-	-	17.0	7.5	-	-
<b>max.</b>	0.14	7.5	1.0	0.025	0.030	20.0	9.5	1.0	0.5

**Typical All-Weld Metal Mechanical Properties**

Ultimate Tensile Strength	N/mm <sup>2</sup>	550 min.
Yield Stress/0.2% Proof Stress	N/mm <sup>2</sup>	380 min.
Elongation on 4D	%	25 min.
Impact Energy CV @ +20°C as-welded	Joules	>100

Wire Dia (mm)		0.6mm	0.8mm	1.0mm	1.2mm	1.6mm	2.4mm	3.2mm
<b>Current Range (Amps)</b>	<b>min.</b>	-	80	120	160	180	-	-
	<b>max.</b>	-	180	240	260	300	-	-
<b>Volt Range (Volts)</b>	<b>min.</b>	-	17	17	18	20	-	-
	<b>max.</b>	-	20	22	26	29	-	-

**Packaging Information**

**Kg Per Reel** - 15 15 15 15 - -

**Storage**

It is recommended that the WB range of wires are stored in a dry heated store at a minimum temperature of 18°C, and a maximum relative humidity of 60%.

**Storage**

**Gas**

Pure Argon or Argon + 2%O<sub>2</sub> mixture

**Gases**

**Flow Rate**

12-16 l/min

**Current Conditions DC+ and Welding Positions**

