

# SW·ER307Si



不 锈 钢 气 体 保 护 焊 丝  
MIG WIRES FOR STAINLESS STEEL

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## 执行标准 CLASSIFICATION

符合 GB/T 29713 S307Si 相当 GB/T 29713 S307Si AWS A5.9 ER307Si ISO 14343-A

## 产品特性 DESCRIPTION

SW-ER307Si 主要成分与 SW-ER307 相同，只是硅含量更高。较高的硅提高了填充金属在熔化极气体保护焊工艺中的可用性。如果母材稀释产生低铁素体或全奥氏体焊缝金属，则焊缝的裂纹敏感性略高于硅含量较低的焊缝金属。

The main composition of SW-ER307Si is the same as that of SW-ER307, with the only difference being its higher silicon content. The increased silicon content enhances the usability of the filler metal in the gas metal arc welding (GMAW) process. However, if base metal dilution results in weld metal with low ferrite content or fully austenitic structure, the crack sensitivity of the weld will be slightly higher than that of weld metal with lower silicon content.

## 应用 APPLICATIONS

常应用于核潜艇、防弹钢板等需要无磁性的特殊场合，也可用于难焊且易开裂的异种钢材焊接。

It is often used in special non-magnetic applications such as nuclear submarines and bulletproof steel plates, and can also be applied to the welding of dissimilar steels that are difficult to weld and prone to cracking.

## 电源类型 Current type

焊枪接正电极 DC+

## 保护气体 Protection

100%Ar

## 焊接位置 WELDING POSITIONS

平焊、角焊、仰焊、立向上焊、立向下焊 Flat, fillet, tilt, vertical up, vertical down

## 熔敷金属化学成分 Chemical composition of welded metal %

| 项目                | C         | Si       | Mn      | P      | S      | Cu    | Ni        | Cr        | Mo    |
|-------------------|-----------|----------|---------|--------|--------|-------|-----------|-----------|-------|
| GB/T Standard     | 0.04-0.14 | 0.65-1.0 | 6.5-8.0 | ≤0.030 | ≤0.030 | ≤0.75 | 8.0-10.75 | 18.5-22.0 | ≤0.75 |
| 例值 Typical values | 0.071     | 0.70     | 6.73    | 0.014  | 0.012  | 0.17  | 8.96      | 18.83     | 0.16  |

## 作业条件 OPERATING CONDITIONS

| 直径 Diameter [mm] |         | Φ0.8   | Φ1.0    | Φ1.2    |
|------------------|---------|--------|---------|---------|
| 电流 Current [A]   | 平焊 Flat | 70~150 | 100~200 | 140~220 |

## 包装 PACKAGING

1kg 5kg 15kg 盘装 Coil 也可以定制其他包装和规格 Other packaging and other diameters: please consult us  
40-1000mm × 5kg 10kg 直条焊丝 Straight Stick Welding Wire