



Techalloy 307 MOD

Description

Techalloy 307 is an austenitic stainless steel solid wire used extensively in automotive exhaust system applications as well as joining dissimilar stainless steels.

Specifications & Approvals:

AWS N/A ASME Section II N/A
 UNS N/A ISO 14343-A 18 8 Mn

Werkstoff Nr.1.4370

Typical Chemical

C	Mn	Si	Cr	Mo	Ni	Nb	N	S	P	Cu	FN WRC
.07	6.6	.90	18.7		8.9			.007	.015		5

Typical Mechanical Properties

Tensile Strength	95.0 PSI	660 MPA
Yield Strength	64.0 PSI	440 MPA
Elongation	36%	

Welding Parameters

	Shielding	Gas Flow	Diameter	Voltage	Amperage
Mig Welding	98/99% Argon + 2/1% Oxygen 97% Argon + 3% CO2	30 to 50 CFH	.035" (0.9mm)	26 to 29	160/210
			.045" (1.14mm)	28 to 32	180/250
			.062" (1.6mm)	29 to 33	200/280
Tig Welding	100% Argon				
Sub Arc Welding	Suitable flux may be used		3/32" (2.5mm)	28 to 30	275/350
			1/8" (3.14mm)	29 to 32	350/450
			5/32" (4.0mm)	30 to 33	400/550

Standard Packages:

Mig Wire– 33# wire basket	Tig Wire– 10# tube/30# Master Carton	SAW– 60# Coil
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