

Classifications

EN ISO 14343-A
AWS A5.9 / SFA-5.9

S 18 8 Mn

ER307 (mod.)

Characteristics and typical fields of application

Thermanit X is a solid wire for submerged arc welding for dissimilar joints, tough buffer layers prior to hardfacing, 14 % manganese steels, 13 – 17 % chromium and heat resistant steels, armour plates, high carbon and quenched & tempered steels

Typical analysis of the wire

	C	Si	Mn	Cr	Ni
wt.-%	0.08	0.90	7.0	19.0	9.0

Typical fluxes to combine

Process	Name	EN ISO 14174
SAW	Marathon 431	S A FB 2 DC

Packaging

Size(s) in mm	Type	Weight
2,0	basket spool	25 kg
2,4	basket spool	25 kg
3,0	basket spool	25 kg
3,0	coil	100 kg
3,2	basket spool	25 kg
4,0	basket spool	25 kg

Other sizes and coil weights on request.

