

AA 307

CATEGORY FCAW Flux-Cored

TYPE Rutile fluxcored stainless steel welding wire for dissimilar welding and buffer layers

APPLICATIONS Welding stainless steel to low alloyed steels (dissimilar welds), buffer layers before hard facing, rails crossings, armour plate, austenitic manganese steels and other difficult to weld steels.

PROPERTIES Smooth drop transfer and stable arc with no spatter losses. Excellent productivity and weldability, better wetting properties compared to solid wires. Excellent weld metal quality and X-ray soundness. Post weld heat treatment (PWHT) can be applied without any problems.

CLASSIFICATION

AWS	A 5.22: E 307 T 0-G
EN ISO	17633-A: T 18 8 Mn R M 3 17633-B: ~TS 307-FB0
DIN: W.Nr.	1.4370
DIN	8556: 18 8 Mn

SUITABLE FOR Dissimilar welding between steel and stainless steel, armor plate, exhaust systems (type 409, 304), high Manganese austenitic steel, difficult to weld steels such as: 42CrMo4, C45, 42MnV7, tool steels etc.

APPROVALS CE approved

WELDING POSITIONS:



WELD DEPOSIT WEIGHT % (M21)

C	Mn	Si	Cr	Ni	Mo
0.10	6.7	0.7	18.50	8.8	-

TYPICAL WELD METAL PROPERTIES (M21)

Heat Treatment	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness HB/HV
				+20°C	-40°C	-100°C	
AW	>400	>620	>35	60		>32	200 HB
Strain hardening							400 HV

AW: as welded

WELDING PARAMETERS / PACKING

Welding Parameters			Packing		
D (mm)	Voltage (V)	Current (A) DC+	spool type	kg / spool	kg / pallet
1.2	20-34	125-280	SD-300	15	1080
1.6	25-35	200-350	SD-300	15	1080

REDRYING TEMPERATURE 150°C / 24hr

GAS ACC. EN ISO 14175 M21