

AA 307P

CATEGORY	FCAW Flux-Cored	
TYPE	All positional 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 T1-4 A 5.22: ~E 307 T1-1
	EN ISO	17633-A: T 18 8 Mn P M (C1) 1
	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:



TYPICAL WELD DEPOSIT WEIGHT % (M21)

C	Mn	Si	Cr	Ni
0.10	6.3	0.7	18.8	9.0

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	475	625	40	60		>32	180 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	22-34	125-265	SD-300	15	1080
1.6	23-36	150-390	SD-300	15	1080

REDRYING TEMPERATURE 150°C / 24hr

GAS ACC. EN ISO 14175 M21