

## 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. Excellent for use in position due to slag support and down hand as well. 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 <sub>p0,2</sub> (N/mm <sup>2</sup> )	R <sub>m</sub> (N/mm <sup>2</sup> )	A <sub>5</sub> (%)	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