

AUSTOMANG 307

STAINLESS STEEL (Austenitic Manganese Steel)

AWS A/SFA 5.4 **E307-16**

CLASSIFICATION:

ISO 3581-B ES307-16

KEY FEATURES:

- 307 is a lime-titania stainless steel electrode
- Deposited metal of 19%-9%Ni-4%Mn stainless steel with the perfect structure of austenite
- The deposited metal has excellent crack resistibility
- Easy work hardening characteristic
- Often used as a buffer layer in hardfacing applications
- Excellent slag detachability
- Easy arc striking-Restriking during welding

APPROVALS: CE

TYPICAL APPLICATIONS:

- Welding of 14% Mn steel, steel armour, hardenable steel
- Welding of difficult to weld steel
- Joining of wear plates to each other and to their supports
- Joining of stainless steels to carbon steels
- Extensively used in steelmaking public works, mining carrying and dredging.
- Building up of rails and buttering layers before hardfacing on 14%Mn steel or on steels of unknown composition or on carbon steels

TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:

С	Mn	Si	Cr	Ni
0.09	4.3	0.9	20.5	9.5

MECHANICAL PROPERTIES OF ALL WELD METAL:					
	Condition	UTS, MPa	EL%		
Specification	As Welded	590 min	30 min		

PARAMETERS - PACKING DATA:						
Ø x L, mm 2.5 x 350 3.15 x 350	Amperage, A 60-80 80-120	AC (70 OCV) /DCEP	All Positions, except vertical Down			
4.0 x 350 5.0 x 450	110-160 150-200	REDRYING CONDITION: 250-300°C for minimum 1 hr.				

Available in Standard carton packing of 10 kg box containing 5 cartons of 2 kg each.

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