



FCAW STAINLESS STEEL
MIGINOX OA 307

SELF SHIELD FLUX CORED WIRE FOR AUSTENITIC Mn STEEL WELDING



CLASSIFICATION : AWS A/SFA 5.22

E307T0-3

KEY FEATURES :

- Flux cored self shielded stainless steel wire of 307 type
- Typical 20Cr-9.5Ni-1Mo-4Mn weld deposit
- Smooth arc, less spatter
- Excellent bead appearance
- Excellent crack resistance with moderate strength

WELDING POSITION :



DCEP

TYPICAL APPLICATIONS :

- Dissimilar steel welding such as austenitic manganese steel to carbon steel
- Repairing cracks in austenitic Mn steel parts

STORAGE / HANDLING :

Keep dry and follow handling instructions mentioned on the box

CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt% :

	C	Mn	Si	Cr	Ni	Mo	S	P
Specification	0.13 max	3.30-4.75	1.0 max	19.5-22.0	9.0-10.5	0.5-1.5	0.03 max	0.04 max

MECHANICAL PROPERTIES OF ALL WELD METAL :

	Condition	UTS, MPa	EL%
Specification	As Welded	590 min	30 min

With mixed gas chemical composition and mechanical properties will be higher.

PARAMETERS - PACKING DATA :

Ø, mm	Electrical Stickout, mm	Voltage, V	Amperage, A	Kg/Spool
1.2	20	23 - 30	120 - 220	12.5
1.6	20	23 - 33	150 - 250	12.5