



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


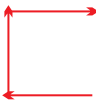
TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:

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

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