

SMAW

For Stainless Steel

STAINARC 307

CLASSIFICATION : AWS A5.4 E307-16

JIS Z3221 D307-16

WELDING POSITIONS :



- Rutile Type Stainless Steel Electrode
- For Joining And Overlaying On Manganese Steels.

DESCRIPTION AND APPLICATIONS

Austenitic rutile coated electrode for joining and overlaying on manganese steels (up to 14% Mn), also for joining dissimilar steels, construction steels to stainless steels, for cushioning layers prior to hardfacing. For repairing of pieces subjected to shocks or wear by friction.

TYPICAL ALL WELD METAL COMPOSITION (Wt%)

C	Mn	Si	Cr	Ni	Fe
0.10	4.50	0.70	19.5	9.5	Bal

TYPICAL ALL WELD METAL MECHANICAL PROPERTIES*

YIELD STRESS	TENSILE STRENGTH	ELONGATION	CVN IMPACT VALUES
465 N/mm ²	660 N/mm ²	35%	-

- in "as welded" condition.

OPERATIONAL AND PACKAGING DATA

ELECTRODE SIZE(mm)	ELECTRODE LENGTH(mm)	WELDING CURRENT RANGE • (amp)	PACKAGING (kg)		
			PKT	CTN	
3.2	350	80-100	2.5	5	20
4.0	350	100-130	2.5	5	20

- Recommended for DC+ or AC operation.

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