

Classification

AWS A5.4

E307-16

Characteristics and typical fields of application

BOHLER FOX S 307 is a Mn-alloyed electrode designed for welding dissimilar joints between stainless and mild or low-alloy steels as well as Mn-steels. BOHLER FOX S 307 offers a crack resistant weld with good mechanical properties.

Corrosion resistance:

Primarily intended for stainless to mild steels connections, but with the same corrosion resistance as 1.4301/ASTM 304.

Base Materials

High-alloy electrode for welding stainless steels to carbon steel, low-alloy steel or Mn-steel.

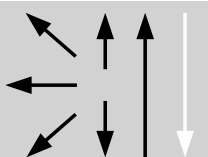
Typical analysis of solid wire (wt.-%)

C	Si	Mn	Cr	Ni	Mo
0.06	0.80	4.0	18.9	10.3	0.6

Mechanical properties of all-weld metal

Heat treatment	Yield strength R _e N/mm ²	Tensile strength R _m N/mm ²	Elongation (L ₀ =5d ₀)	Impact work ISO-V KV J	Hardness
	MPa	MPa	%	+ 20 °C	HB
As Welded	460	600	35	50	200

Operating data

	Polarity DC (+)
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Approvals

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Size, Packaging and Electrical Operating Data

Size mm	Kg / Pack	Kg / Box	Amperage (A)
2.50 × 350	4.10	12.30	50 – 80
3.25 × 350	4.10	12.30	80 – 120
4.00 × 450	5.40	16.20	100 – 160
5.00 × 450	5.40	16.20	160 – 200