



FCW 307

*High productivity
Metal cored 307 type*

Classification

AWS A5.22 : ~E307T0-1/-4

ISO 17633-A : T 18 8 Mn R M21(C1) 3

Description & Applications

Metal cored wire for gas shielded (Ar + CO₂) arc welding of austenitic stainless steels and manganese steels considered difficult to weld or misidentified. Nonmagnetic stainless steel, resistant against hot cracking and work hardening weld deposit. Ideal as buffer layer before hardfacing of grades sensitive to cracking or in case of dissimilar joints between stainless steel and steel construction. Used for repair parts exposed to shocks and friction. Wire especially designed for flat position welding.

Main applications: Civil engineering, road, rail and fluvial, quarry, cement.

Typical Chemical Composition (%)

C	Si	Mn	Cr	Ni	Mo	Cu	P	S	Fe
0.10	0.90	6.0	19.0	9.5	0.15	0.10	0.02	0.008	Rem.

All Weld Metal Mechanical Properties

R _{p0.2} (MPa)	R _m (MPa)	A ₅ (%)	KV (J)		Hardness
480	630	40	+20°C	50	170 HB as welded 500 HB work hardening

Welding Current & Instructions

Welding mode	Ø (mm)	Welding parameters			Shielding Gas
		Current (A)	Voltage (V)	Stick-out (mm)	
FCAW = +	1.2	100 - 280	23 - 33	10 - 25	ISO 14175 : M21 (Ar/CO ₂) 12 - 20 l/min
	1.6	150 - 400	23 - 35	10 - 25	

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