



FCW 307M

Metal cored wire 307 type

Classification

AWS A5.9 : ~EC307

ISO 17633-A : T 18 8 Mn M M21 1

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. 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	0.60	6.00	19.5	8.5	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
450	630	40	+20°C	70	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 = + / pulsed	1.2 1.6			12 - 25	ISO 14175 : M21 (Ar/CO ₂) 10 - 20 l/min

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