



# FCW 307P

*Metal cored 307 type  
For all positions*

## Classification

AWS A5.22 : ~E307T0-4

ISO 17633-A : T 18 8 Mn R 21 1

## Description & Applications

Metal cored wire for gas shielded (Ar + CO<sub>2</sub>) 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. Used for welding in all positions.

**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	0.7	6.0	19.0	9.0	0.15	0.10	0.02	0.008	Rem.

## All Weld Metal Mechanical Properties

R <sub>p0.2</sub> ( MPa )	R <sub>m</sub> ( MPa )	A <sub>5</sub> ( % )	KV ( J )		Hardness
410	600	30	+20°C	60	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	130 - 270	22 - 35	12 - 25	ISO 14175 : M21 (Ar/CO <sub>2</sub> ) 10 - 20 l/min



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