

Meltolit

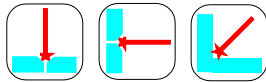
307R

AWS A 5.4: E307-16 ISO 3581-A: E 18 8 Mn R 32

General Description

Rutile -basic electrode austenitic stainless steel alloy with high Mn-content for welding and hardsurfacing of Mn steel (14%), for buffer layer before hardsurfacing, welding of difficult steels and repairs of materials exposed to impact. Easy to use, stable arc, spatter free, self-releasing slag and crack free weld metal.

Welding Position



Polarity

DC+ / AC

Coating

Rutile-Basic

Base Materials

Stainless Steel, austenitic steel with Mn, tool steels, unalloyed and low alloyed steel

Mechanical Properties

<i>R_m</i> (Mpa)	<i>R_{p 0,2}</i> (Mpa)	<i>A₅</i> (%)	<i>KV(j)</i>	<i>Hardness (HB)</i>
>600	>400	>30	+20°C>70	200 HB , Work hardening up to 500 HB

Chemical Analysis (%)

C	Mn	Si	Cr	Ni
0,10	4,5	0,8	18,0	8,5

Package

Dimension(mm)	2,5x350	3,25 x 350	4,0 x 350	5,0x350
Kg/box	4,5/13,5	5/15	6,5/19,5	6,5/19,5
Ampere(A)	70	100	125	160

Equivalent Consumables

TIG	Meltolit 307Si XT
MIG	Meltolit 307Si XM
FCW/MCW	Meltolit 707 FCW/707 MCW

Redrying if necessary for 2 hours in 300°C. Never preheat Mn-steels due to the sensitivity to cracks.