






CEWELD AA 307

TYPE	Rutile fluxcored stainless steel welding wire for dissimilar welding and buffer layers																				
APPLICATIONS	CEWELD AA 307 is designed for welding stainless steel to low alloyed steels (dissimilar welds), buffer layers before hardfacing, rails crossings, armour plate, austenitic manganese steels and other difficult to weld steels.																				
PROPERTIES	Smooth drop transfer and stable arc with no spatter losses. Excellent productivity and weldability, better wetting properties compared to solid wires. Excellent weld metal quality and X-ray soundness.																				
CLASSIFICATION	<table border="0"> <tr> <td>AWS</td> <td>A 5.22: ~E307T0-G</td> </tr> <tr> <td>EN ISO</td> <td>17633-A: T 18 8 Mn R M21 3</td> </tr> <tr> <td>F-nr</td> <td>6</td> </tr> <tr> <td>FM</td> <td>5</td> </tr> <tr> <td>W.Nr.</td> <td>1.4370</td> </tr> </table>	AWS	A 5.22: ~E307T0-G	EN ISO	17633-A: T 18 8 Mn R M21 3	F-nr	6	FM	5	W.Nr.	1.4370										
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SUITABLE FOR	<p>19% Cr / 9% Ni / 7% Mn, ISO 15608: 8.1 Cr ≤ 19 % 1.3401, 1.5637, 1.5680, 1.4370 X 20 Cr 13, X 8 Cr 17, X 22 CrNi 17, X 5 CrNi 17, G-X 20 Cr 14 mix S355 42CrMo4, C45, 42MnV7, X120Mn12, 10 Ni 14, 12 Ni 19 etc. ASTM 307, 304, (409, 403, 405, 410, 420, 430, 440, 501, 502) Amor</p>																				
APPROVALS	No Approvals Found																				
WELDING POSITIONS	<div style="display: flex; gap: 10px;">    </div>																				
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	<table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <thead> <tr> <th>C</th> <th>Si</th> <th>Mn</th> <th>P</th> <th>S</th> <th>Cr</th> <th>Ni</th> <th>FN</th> <th>FS</th> <th>FNW</th> </tr> </thead> <tbody> <tr> <td>0.1</td> <td>0.7</td> <td>6.5</td> <td>0.01</td> <td>0.01</td> <td>18.5</td> <td>9</td> <td>3.3</td> <td>1.6</td> <td>9.1</td> </tr> </tbody> </table>	C	Si	Mn	P	S	Cr	Ni	FN	FS	FNW	0.1	0.7	6.5	0.01	0.01	18.5	9	3.3	1.6	9.1
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ALL WELD MECHANICAL PROPERTIES	<table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <thead> <tr> <th rowspan="2">Heat Treatment</th> <th rowspan="2">R_{P0,2} MPa</th> <th rowspan="2">R_m MPa</th> <th rowspan="2">A₅ (%)</th> <th colspan="2">Impact Energy (J) ISO-V</th> <th rowspan="2">Hardness Brinell Hardness</th> </tr> <tr> <th>RT</th> <th>0°C</th> </tr> </thead> <tbody> <tr> <td>As Welded /</td> <td>400</td> <td>620</td> <td>35</td> <td>90</td> <td>50</td> <td>Avg. 400</td> </tr> </tbody> </table>	Heat Treatment	R _{P0,2} MPa	R _m MPa	A ₅ (%)	Impact Energy (J) ISO-V		Hardness Brinell Hardness	RT	0°C	As Welded /	400	620	35	90	50	Avg. 400				
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REDRYING TEMPERATURE	140°C / 24 hr																				
GAS ACCORDING EN 14175	M21																				



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AA 307 1,2MM

Type	KG/unit	EANCode
BS-300	15	8720663413284
D-200	5	8720663413291