



# FCO 307

*Maintenance and repair  
Stainless steel open arc wire*

## Classification

AWS A5.22 : ~E307T0-3  
EN 14700 : T Fe10

ISO 17633-A : T 18 8 Mn U NO 3

## Description & Applications

Flux cored wire in stainless steel without gas use for welding austenitic stainless steels and manganese steels considered difficult to weld or misidentified. Could be used as buffer layer before hardfacing. Good resistance against cavitation, shocks and corrosion

**Main applications:** Civil engineering, road, rail and fluvial, quarry, cement. Ideal as buffer layer before hardfacing of grades sensitive to cracking or in case of dissimilar joints between stainless steel and steel construction.

## Typical Chemical Composition ( % )

	C	Si	Mn	Cr	Ni	Mo	Cu	Nb	P	S
Min			4.5	17.0	7.0					
Max	0.20	1.2	7.5	20.0	10.0	0.3	0.5	1.5	0.035	0.025
Type	0.10	0.50	6.0	19.0	9.0	0.10	0.10	0.01	0.015	0.008

## All Weld Metal Mechanical Properties

	R <sub>p0.2</sub> ( MPa )	R <sub>m</sub> ( MPa )	A <sub>5</sub> ( % )	Hardness HB	
Min	350	500	25	As welded	Work hardened
Max					
Type	400	650	32	170	500

## Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters			Shielding Gas
		Current (A)	Voltage (V)	Stick out (mm)	
FCAW = +	1.2	100 - 300	21 - 35	12 - 25	-
	1.6	150 - 300	24 - 35	15 - 25	

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