



FCW 307

*High productivity
Metal cored 307 type*

Classification

AWS A5.22 : ~E307T0-1/-4

ISO 17633-A : T 18 8 Mn R M21(C1) 3

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. Used for repair parts exposed to shocks and friction. 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
Min			4.5	17.0	7.0				
Max	0.20	1.2	7.5	20.0	10.0	0.3	0.5	0.035	0.025
Type	0.10	0.90	6.0	19.0	9.5	0.15	0.10	0.020	0.008

All Weld Metal Mechanical Properties

	R _{p0.2} (MPa)	R _m (MPa)	A ₅ (%)	KV (J)	Dureté HB	
Min	350	500	25		As welded	Work hardened
Max						
Type	480	630	40	+20°C 50	170	500

Welding Current & Instructions

Welding mode	Ø (mm)	Welding parameters			Shielding Gas
		Current (A)	Voltage (V)	Stick-out (mm)	
FCAW = +	1.2	100 - 280	23 - 33	10 - 25	ISO 14175 : M21 (Ar/CO ₂) 12 - 20 l/min
	1.6	150 - 400	23 - 35	10 - 25	



FT En-CN02-190731

Liability: This document is intended to assist the user in choosing the product. It is up to the user to verify that the chosen product is suitable for applications for which it is intended. The company FSH Welding Group reserves the right to alter specifications without prior notice of its products. The descriptions, illustrations and specifications are for reference only and cannot be held liable for FSH Welding Group. **Fumes:** Consult information on MSDS, available upon request.

www.fsh-welding.com - info@fsh-welding.fr