



# FCW 307M

*Metal cored wire 307 type*

## Classification

AWS A5.9 : ~EC307

ISO 17633-A : T 18 8 Mn M M12 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.

**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	0.60	6.0	19.5	8.5	0.15	0.10	0.020	0.015

## All Weld Metal Mechanical Properties

	R <sub>p0.2</sub> ( MPa )	R <sub>m</sub> ( MPa )	A <sub>5</sub> ( % )	KV ( J )	Hardness HB	
Min	350	500	25		As welded	Work hardened
Max						
Type	450	630	40	+20°C 70	170	500

## Welding Current & Instructions

Welding mode	Ø (mm)	Welding parameters			Shielding Gas
		Current (A)	Voltage (V)	Stick-out (mm)	
FCAW = + / pulsed	1.2 1.6			12 - 25	ISO 14175 : M12 (Ar/O <sub>2</sub> ) 10 - 20 l/min



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