



# FCW 307P

*Metal cored 307 type  
For all positions*

## Classification

AWS A5.22 : ~E307T1-1/-4

ISO 17633-A : T 18 8 Mn P M21(C1) 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. Used for repair parts exposed to shocks and friction. Used for welding in all positions.

**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	0.030	0.025
Type	0.11	0.80	6.0	19.0	9.5	0.15	0.10	0.020	0.008

## All Weld Metal Mechanical Properties

	R <sub>p0.2</sub> ( MPa )	R <sub>m</sub> ( MPa )	A <sub>5</sub> ( % )	KV ( J )	Dureté HB	
Min	350	500	25		As welded	Work hardened
Max						
Type	480	650	32	+20°C 60	170	500

## Welding Current & Instructions

Welding mode	Ø (mm)	Welding parameters			Shielding Gas
		Current (A)	Voltage (V)	Stick-out (mm)	
FCAW = +	1.2	130 - 270	22 - 35	12 - 25	ISO 14175 : M21 (Ar/CO <sub>2</sub> ) 10 - 20 l/min



FT En-CN03-190731

**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](http://www.fsh-welding.com) - [info@fsh-welding.fr](mailto:info@fsh-welding.fr)