



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

AWS	A 5.22: ~E307T0-G
EN ISO	17633-A: T 18 8 Mn R M21 3
W.Nr.	1.4370
F-nr	6
FM	5

SUITABLE FOR

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

APPROVALS

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

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

MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V		Hardness
				RT	0°C	
As Welded	400	620	35	90	50	400 HB

REDRYING 140°C / 24 hr

GAS ACC. EN ISO 14175 M21



CEWELD AA 307

AA 307 1,2MM

Packaging	KG/unit	EanCode
BS-300	15	8720663413284
D-200	5	8720663413291