



# CEWELD AA 307P

**TYPE** All positional Rutile fluxcored stainless steel welding wire for dissimilar welding and buffer layers

**APPLICATIONS** Welding stainless steel to low alloyed steels (dissimilar welds), buffer layers before hard facing, 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. Post weld heat treatment (PWHT) can be applied without any problems.

**CLASSIFICATION**

|        |                            |
|--------|----------------------------|
| AWS    | A 5.22: ~E307T1-4          |
| EN ISO | 17633-A: T 18 8 Mn R M21 1 |
| 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** CE

**WELDING POSITIONS**

**TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)**

| C   | Si  | Mn  | P     | Cr | Ni  | Mo  | S     |
|-----|-----|-----|-------|----|-----|-----|-------|
| 0.1 | 0.7 | 6.5 | 0.015 | 19 | 9.5 | 0.3 | 0.015 |

**MECHANICAL PROPERTIES**

| Heat Treatment | R <sub>P0,2</sub> (MPa) | R <sub>m</sub> (MPa) | A <sub>5</sub> (%) | Impact Energy (J) ISO-V |        | Hardness |
|----------------|-------------------------|----------------------|--------------------|-------------------------|--------|----------|
|                |                         |                      |                    | RT                      | -110°C |          |
| As Welded      | 475                     | 625                  | 40                 | 60                      | 35     | 180 HB   |

**REDRYING** 140°C / 24 hr

**GAS ACC. EN ISO 14175** M21