



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	PA PB PC									
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									



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AA 307 1,2MM

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