



# DAIKOFCW 307



AUSTENITIC STAINLESS STEELS

307

## DESCRIPTION

### Rutile flux cored wire for flat and horizontal position

The easy handling and the high deposition rate result in high productivity, excellent welding performance and very low spatter formation. The wire shows good wetting behaviour and a finely rippled surface pattern. The weld metal offers exceptionally high ductility and elongation together with outstanding crack resistance. Resistance to hot cracking is provided by the high manganese content. Good resistance to embrittlement when operating at service temperatures from -100°C up to 650°C. The weld metal work hardens and offers good resistance to cavitation.

## SPECIFICATIONS

ISO 17633-A	T 18 8 Mn R M21 3	AWS A5.22	(E307T0-1/4)
DIN	-	Werkstoff Number	-
Certifications	-	Shielding	M21
Positions	PA, PB, PC	Current	DC+

## ASME QUALIFICATIONS

F-No (QW432)	6
A-No (QW442)	-

## FERRITE

~5 FN

## PREN

19.2

## HARDNESS

-

## CHEM. COMP. %

### DEFAULT

C	0.07
Mn	6.4
Ni	8.1
Cr	19.2
P	0.02
S	0.008
Si	0.6

## MECHANICAL PROPERTIES

	MIN	VARIANT
Tensile strength $R_m$ MPa	500	580
Yield strength $R_{p0.2}$ MPa	350	390
Elongation A ( $L_0=5d_0$ ) %	25	40
Impact Charpy ISO-V	-	45J
Impact Charpy ISO-V	-	-

## WELDING PARAMETERS

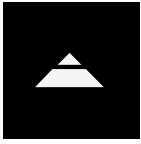
	1.2 mm	1.6 mm
Ampere	120A - 280A	200A - 350A
Voltage	22V - 30V	26V - 30V
Packaging	Ø 1,2÷1,6mm	Ø 1,2÷1,6mm
Packaging Type	BS300 spool	BS300 spool

V 01/2024



The information in this datasheet is the result of detailed research and is considered accurate as of the publication date. However, we cannot guarantee its complete accuracy, and it is subject to change without notice. Actual results may vary due to many factors like welding procedures, material composition, temperature conditions, bevel configuration, and specific manufacturing techniques. We accept no liability for any errors or omissions in this datasheet. For the most current information, please visit [www.daikowelding.com](http://www.daikowelding.com).





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DESCRIPTION

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## APPLICATION

These consumables are versatile for mixed welding applications, including mild, stainless, hardenable, and armor steels, with or without preheat. Their high manganese content provides tolerance to dilution, resisting hot cracking. This makes them a viable alternative to high nickel weld metal in joints between cast iron and stainless steels. Post-weld heat-treated weldments maintain ductility with satisfactory toughness down to -50°C. They offer reasonable scaling resistance up to 850°C. These consumables can function as buffer layers for welding or reclaiming 13% Mn steel in rock crushing plants and earth-moving equipment. They also work well as buffer layers on cast iron before hard surfacing. Additionally, they serve as surfacing consumables, work-hardening from 200 to 400 HV, suitable for repairing alloy rails, crossing parts, frogs, etc., without requiring preheat. However, note that the work-hardening rate is lower than 13% Mn steel, and overlays of more than one layer may collapse under heavy rolling loads.

## ALLOY TYPE

Strong tough austenitic weld metal composition for dissimilar joints and buffer layers.

## MICROSTRUCTURE

Consists of austenite with approximately 5FN.

## MATERIALS

Dissimilar combinations of C-Mn, stainless, hardenable, wear-resistant and armour steels. Suitable for 13% Mn steel also known as Hadfield steel.

## WELDING & PWHT

Preheating is typically unnecessary unless dealing with substantial section thickness, with an exception for higher carbon hardenable steels where consideration of Heat-Affected Zone (HAZ) properties in relation to service conditions is imperative. When welding 13%Mn steels, the objective is to minimize embrittlement and cracking, necessitating the implementation of specific controls. These controls include avoiding preheating, restricting the maximum interpass temperature to 150°C, adhering to low heat input practices, employing small weld beads, and resorting to water cooling if deemed necessary.

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