

SUNWELD 307

Stainless Steel Electrode



CLASSIFICATION

AWS A 5.4 : E 307-15

CHARACTERISTICS

A rutile type stainless steel electrode suitable for the welding of austenitic manganese steel to carbon steel. Welding & surfacing of rails. The weld metal has excellent crack resistance and good scaling resistance up to 850°C.

APPLICATIONS

SUNWELD 307 find extensive use for joining dissimilar steels, 13 Mn steels with reduced weld ability and for cladding carbon steels. It can also be used as a buffer layer prior to hard facing.

CHEMICAL ANALYSIS OF WELD METAL % (TYPICAL):

C	Mn	Si	Cr	Ni
0.07	6.00	0.50	19.00	9.80

MECHANICAL PROPERTIES OF ALL WELD METAL (TYPICAL)

Ultimate Tensile Strength	Elongation
600.0 N/mm ²	38.0 %

CURRENT RANGE & PACKING DATA:

Size (mm)	Length (mm)	Current(Amp) AC or DC(+)	Quantity of Electrodes in a Carton	Quantity of Electrodes in a Cardboard box
2.50	350	60-80	2 Kg	10 Kg
3.15	450	80-100	2 Kg	10 Kg
4.00	450	100-140	2 Kg	10 Kg
5.00	450	140-180	2 Kg	10 Kg

RECOMMENDATIONS:

SUNWELD 307 find extensive use for joining dissimilar steels, 13 Mn steels with reduced weld ability and for cladding carbon steels. It can also be used as a buffer layer prior to hard facing.