



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, A 5.22: ~E307T1-1
EN ISO	17633-A: T 18 8 Mn R M21 1, 17633-A: T 18 8 Mn R C1 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 _{P0.2} (MPa)	R _m (MPa)	A ₅ (%)	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