



707 FCW

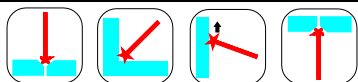
EN ISO 17633-A: T 18 8 Mn R M21 3
AWS A5.22 E307 T0-1/4

DESCRIPTION

Routile stainless flux cored wire. Joining and hardsurfacing of large machine parts, buffer layer before hardfacing, joining austenitic manganese steels, 14% Mn steels, difficult to weld steels, armour steels and tool steels.

Attractive bead appearance, very good penetration and high productivity.

WELDING POSITIONS



CURRENT TYPE

DC(+)

GAS

Ar/Co2(M21)

MECHANICAL PROPERTIES

<i>Rm (Mpa)</i>	<i>Rp 0,2 (Mpa)</i>	<i>A5 (%)</i>	<i>KV(j)</i>	<i>Hardness</i>
630	480	40	+20°C : 50	As welded 170 HB Work hardening to 500 HB

TYPICAL CHEMICAL COMPOSITION(%)

C	Si	Mn	Cr	Ni	S	P
0,1	0,9	6,0	19,0	9,5	0,008	0,02

PACKING INFORMATION AND WELDING PARAMETERS

Dimension(mm)	1,2	1,2	1,6	
Spool(kg)	5	15	15	
Amperage(A)	100-280	100-280	150-400	
Voltage(V)	23-33	23-33	23-35	
Stick-out(mm)	10-25	10-25	10-25	
Gas flow(l/min)	12-20	12-20	12-20	

EQUIVALENT CONSUMABLES

MMA	Meltolit 307 E
TIG	Meltolit 307 XT
MIG	Meltolit 307 XM