



707 FCW-PW

EN ISO 17633-A: T 18 8 Mn P M21/C1 1
AWS A5.22 E307 T1-1/4

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. Especially for welding out of position.

WELDING POSITIONS	CURRENT TYPE	GAS
	DC(+)	Ar/Co2(M21)

MECHANICAL PROPERTIES

Rm (Mpa)	Rp 0,2 (Mpa)	A5 (%)	KV(j)	Hardness
600	410	30	+20°C : 60	As welded 170 HB Work hardening to 500 HB

TYPICAL CHEMICAL COMPOSITION(%)

C	Si	Mn	Cr	Ni	S	P
0,11	0,8	6,0	19	9,5	0,008	0,02

PACKING INFORMATION AND WELDING PARAMETERS

Dimension(mm)	1,2	1,2		
Spool(kg)	5	15		
Amperage(A)	130-270	130-270		
Voltage(V)	22-35	22-35		
Stick-out(mm)	12-25	12-25		
Gas flow(l/min)	10-20	10-20		

EQUIVALENT CONSUMABLES

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