



707 FCW-OA

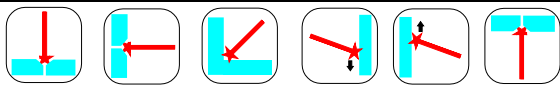
AWS A 5.22: E307T1-1/4

EN ISO 17633-A: T Z 18 8 Mn N P NO/C1 1

DESCRIPTION

Special flux cored self shielded austenitic stainless steel wire for open arc welding. The weld beads produced have a self-releasing slag covering that leaves a clean surface. Good quality welds may be obtained, even when they are used in difficult weather conditions. Specially designed for out of position welding. Typical applications: Repair jobs on high carbon steel and thick or restrained parts. Joining austenitic manganese steels, buffer layers on manganese steels or on hardenable or unknown steels before hardfacing, joining armour plates etc.

WELDING POSITIONS



CURRENT

DC +

GAS

Self shielded
Or C1(CO₂)

BASE MATERIALS

Difficult to weld steels, high carbon steels, manganese steels

MECHANICAL PROPERTIES

<i>R_m</i> (Mpa)	<i>R_{p 0,2}</i> (Mpa)	<i>A5</i> (%)	<i>KV(j)</i>	<i>Hardness</i>
650	490	35	+20°: 80	As welded: 170HB W-H:<500HB

WELD METAL COMPOSITION(%)

C	Mn	Si	Cr	Ni	N		
0,1	6,5	0,8	19,0	8,2	0,1		

PACKAGING AND WELDING PARAMETERS

Dimension (mm)	1,2	1,2
Welding positions	PA-PB / 1G, 1F, 2F	PF / 3Gu
Current (A)	160-180	130-150
Stick out (mm)	≥15	25-30
Volt	27-29	24-25
Technique	Stringer bead	Oscillated bead

EQUIVALENT FILLER METALS

MMA	Meltolit 307 E
Mig/TIG	Meltolit 307 XM/XT
FCW	Meltolit 707 FCW/FCW-PW