

FLUXINOX 307 is an alloyed rutile cored wire for crack-resistant joining and surfacing of heat treatable steels, armour plates, corrosion resisting steels and high manganese steels. It is also suitable for joining austenitic stainless steels to unalloyed steels. The weld metal is suitable for operating temperatures up to 300 °C, and is non-scaling up to 850°C. It is highly rust and corrosion resistant, and will harden by cold working.

Classification

EN ISO	17633-A: T 18 8 Mn R C 3
EN ISO	17633-A: T 18 8 Mn R M 3

Chemical analysis (Typical values in %)

C	Mn	Si	Cr	Ni
0.04	6.5	0.7	19	9

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation A5 (%)	Impact Energy ISO - V (J)
				20 °C
As Welded	≥ 400	600 - 700	≥ 30	≥ 30

Gas test: 82% Ar+18% CO₂

Shielding Gas - EN ISO 14175 : C1, M21

Materials

Oteluri placate;Imbinari eterogene (otel autenitic cu otel feritic)

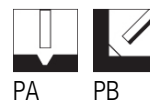
X120Mn12 (1.3401)

Storage

Keep dry and avoid condensation

Current condition and welding position

DC+



Packaging data

Packaging Type	BS300
Diam(mm) / weight(kg)	15.0
1.0	W000281316
1.2	W000281317