

Stainless Steel SMAW Electrodes

G307

AWS A5.4 E307-16
JIS Z 3221 ES307-16
ISO 3581-A-E 18 9 Mn Mo R

Product Features:

- More higher Mn content than 308, austenite structure weld metal.
- High work hardening tendency, no magnetism.
- Good crack resistance, easy slag removal and less spatter loss.
- High welding performance, good arc stability.

Applications:

- Suitable for dissimilar metal welding on manganese steel to carbon steel castings or forgings.

Typical chemical composition of all weld metal (wt%)

C	Si	Mn	Ni	Cr	Mo	Fe
0.06	0.88	3.46	9.39	18.55	0.87	Bal.

Typical mechanical properties of all weld metal

Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation %
463	605	43

Size (mm) & recommended welding parameters (A) AC or DC+

Diameter / Length	2.6/300	3.2/350	4.0/350	5.0/350
Flat position	60~85	85~120	115~150	150~200
Vertical / overhead position	50~70	75~105	95~130	----

Note:

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