

S.S. SMAW Electrodes

GL307HM

AWS A5.4 E307-15 (mod.)

Product Features:

- Austenitic (non-magnetic) basic coated stainless steel electrode for joining and overlaying on manganese steels (up to 14% Mn).
- Excellent welding performance in the vertical and overhead positions.
- Weld metal contains 6.0% Mn provide high work hardening tendency and good crack resistance.
- Easy slag removal and less spatter loss.

Applications:

- Suitable for dissimilar metal joining or overlaying on Manganese steel to carbon steel casing or forgings.

Guideline in Usage:

1. 250~300°C x 1 hr baking prior to use.
2. Proper cleaning of welding groove or joint surface before welding and complete removal of spatter after welding
3. Recommending low electrical current for avoiding defects such as core wire overheat and coating peeling off.

Typical chemical composition of all weld metal (wt%)

C	Si	Mn	Ni	Cr	Mo	P	S
0.09	0.32	6.0	9.82	18.88	0.1	0.018	0.006

Typical mechanical properties of all weld metal

Tensile Strength N/mm ²	Elongation %
640	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	85~110	115~140	150~190
Vertical / overhead position	50~75	75~100	95~130	----

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