

# Stainless Steel Flux Cored Wire

## GMX307

AWS A5.22 E307T1-1/4  
A5.22M E307T1-1/4  
JIS Z 3323 TS307-FB1  
ISO 17633-A-T 189Mn Mo P C1 1, M21 1

### Product Features:

- GMX307 is especially developed for out-of-position welding. The smooth weld metal transfer and easy slag removal eliminates unnecessary clean up. The weld bead is uniform, flat to slightly concave and free from porosity.
- Penetration is complete and easy to obtain the flat equal weld leg.
- The special chemical content helps minimize crack sensitivity.

### Guideline in Usage :

- Use general CO<sub>2</sub> welding machine, but loosen the wire-feeding roller.
- This wire is formulated for using 75% Argon plus 25% CO<sub>2</sub> gas shielded or straight CO<sub>2</sub> gas. However, the 75%Ar / 25%CO<sub>2</sub> mixture gas will produce a smoother arc with less spatter and slight higher yield and tensile strength.

Typical chemical composition of all-weld metal (wt%)

| C    | Si   | Mn   | Ni   | Cr    | Mo   | Fe   |
|------|------|------|------|-------|------|------|
| 0.08 | 0.84 | 4.74 | 9.65 | 19.72 | 1.19 | Bal. |

Typical mechanical properties of all weld metal

| Yield Strength<br>N/mm <sup>2</sup> | Tensile Strength<br>N/mm <sup>2</sup> | Elongation<br>% |
|-------------------------------------|---------------------------------------|-----------------|
| 486                                 | 634                                   | 31              |

Size (mm) & recommended welding parameters

| Diameter      |                      | 1.2mm                                     | 1.6mm                                     |
|---------------|----------------------|---|---|
| Polarity      |                      | DC+                                       | DC+                                       |
| Ampere (A)    | Flat position        | 160~220                                   | 220~300                                   |
|               | Vertical up position | 90~130                                    | -   |
| Shielding Gas |                      | CO <sub>2</sub> /80%Ar+20%CO <sub>2</sub> | CO <sub>2</sub> /80%Ar+20%CO <sub>2</sub> |

### Note:

Goodweld Corporation  
No.99, Huangong Rd. Yongkang Tainan, Taiwan  
Phone: 886-6-2331003 Fax: 886-6-2333213  
All Right Reserved

**GOOD**  
**GOODWELD**  
[www.goodweld.com.tw](http://www.goodweld.com.tw)