



# CEWELD AA 307

|                                             |                                                                                                                                                                                                                                                                                                         |                            |                      |                    |                         |      |     |          |        |     |
|---------------------------------------------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------------------|----------------------|--------------------|-------------------------|------|-----|----------|--------|-----|
| TYPE                                        | Rutile fluxcored stainless steel welding wire for dissimilar welding and buffer layers                                                                                                                                                                                                                  |                            |                      |                    |                         |      |     |          |        |     |
| APPLICATIONS                                | CEWELD AA 307 is designed for welding stainless steel to low alloyed steels (dissimilar welds), buffer layers before hardfacing, rails crossings, armour plate, austenitic manganese steels and other difficult to weld steels.                                                                         |                            |                      |                    |                         |      |     |          |        |     |
| PROPERTIES                                  | Smooth drop transfer and stable arc with no spatter losses. Excellent productivity and weldability, better wetting properties compared to solid wires. Excellent weld metal quality and X-ray soundness.                                                                                                |                            |                      |                    |                         |      |     |          |        |     |
| CLASSIFICATION                              | AWS                                                                                                                                                                                                                                                                                                     | A 5.22: ~E307T0-G          |                      |                    |                         |      |     |          |        |     |
|                                             | EN ISO                                                                                                                                                                                                                                                                                                  | 17633-A: T 18 8 Mn R M21 3 |                      |                    |                         |      |     |          |        |     |
|                                             | W.Nr.                                                                                                                                                                                                                                                                                                   | 1.4370                     |                      |                    |                         |      |     |          |        |     |
|                                             | F-nr                                                                                                                                                                                                                                                                                                    | 6                          |                      |                    |                         |      |     |          |        |     |
|                                             | FM                                                                                                                                                                                                                                                                                                      | 5                          |                      |                    |                         |      |     |          |        |     |
| SUITABLE FOR                                | <b>19% Cr / 9% Ni / 7% Mn, ISO 15608: 8.1 Cr ≤ 19 %</b><br>1.3401, 1.5637, 1.5680, 1.4370<br>X 20 Cr 13, X 8 Cr 17, X 22 CrNi 17, X 5 CrNi 17, G-X 20 Cr 14 mix S355<br>42CrMo4, C45, 42MnV7, X120Mn12, 10 Ni 14, 12 Ni 19 etc.<br>ASTM 307, 304, (409, 403, 405, 410, 420, 430, 440, 501, 502)<br>Amor |                            |                      |                    |                         |      |     |          |        |     |
| APPROVALS                                   |                                                                                                                                                                                                                                                                                                         |                            |                      |                    |                         |      |     |          |        |     |
| WELDING POSITIONS                           | <div>PA</div> <div>PB</div> <div>PC</div>      |                            |                      |                    |                         |      |     |          |        |     |
| TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%) | C                                                                                                                                                                                                                                                                                                       | Si                         | Mn                   | P                  | S                       | Cr   | Ni  | FN       | FS     | FNW |
|                                             | 0.1                                                                                                                                                                                                                                                                                                     | 0.7                        | 6.5                  | 0.01               | 0.01                    | 18.5 | 9   | 3.3      | 1.6    | 9.1 |
| MECHANICAL PROPERTIES                       | Heat Treatment                                                                                                                                                                                                                                                                                          | R <sub>P0,2</sub> (MPa)    | R <sub>m</sub> (MPa) | A <sub>5</sub> (%) | Impact Energy (J) ISO-V |      |     | Hardness |        |     |
|                                             |                                                                                                                                                                                                                                                                                                         |                            |                      |                    | RT                      |      | 0°C |          |        |     |
|                                             | As Welded                                                                                                                                                                                                                                                                                               | 400                        | 620                  | 35                 | 90                      |      | 50  |          | 400 HB |     |
| REDRYING                                    | 140°C / 24 hr                                                                                                                                                                                                                                                                                           |                            |                      |                    |                         |      |     |          |        |     |
| GAS ACC. EN ISO 14175                       | M21                                                                                                                                                                                                                                                                                                     |                            |                      |                    |                         |      |     |          |        |     |



# CEWELD AA 307

AA 307 1,2MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| BS-300    | 15      | 8720663413284 |
| D-200     | 5       | 8720663413291 |