



# 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**

**19% Cr / 9% Ni / 7% Mn, ISO 15608: 8.1 Cr ≤ 19 %**  
 1.3401, 1.5637, 1.5680, 1.4370  
 X 20 Cr 13, X 8 Cr 17, X 22 CrNi 17, X 5 CrNi 17, G-X 20 Cr 14 mix S355  
 42CrMo4, C45, 42MnV7, X120Mn12, 10 Ni 14, 12 Ni 19 etc.  
 ASTM 307, 304, (409, 403, 405, 410, 420, 430, 440, 501, 502)  
 Amor

**APPROVALS**

**WELDING POSITIONS**



**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