

Description and Application

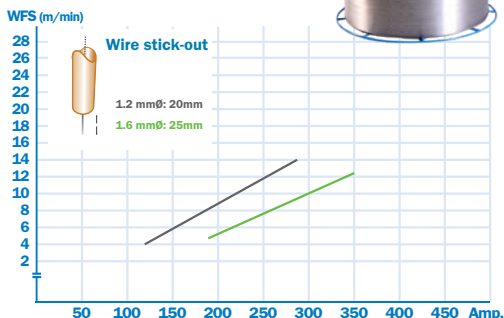
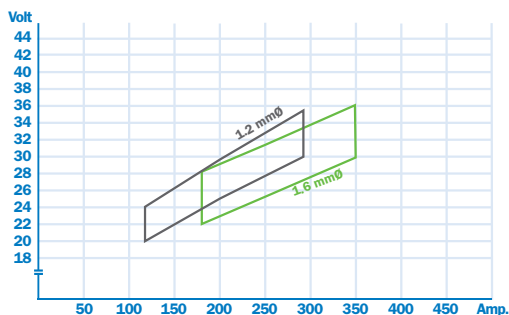
This is a versatile CrNiMn rutile flux cored wire that operates with a stable, almost spatter free arc to produce a shiny, smooth weld bead surface with a self-releasing slag.

The weld metal offers exceptionally high ductility and elongation combined with outstanding crack resistance due to the high manganese content. The weld deposit also work-hardens and provides good wear and friction resistance.

DW-307 was primarily designed for difficult to weld steels such as austenitic high manganese steels and for use in buffer layers under hard facing materials. But due to its low nickel content, it also provides a cost effective alternative to 309 welding materials for general dissimilar welding of mild steel to stainless steel.



Recommended Parameter Range, for flat position



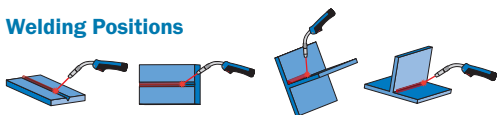
Typical Chemical Analysis (wt. %)

C	Si	Mn	P	S	Ni	Cr	Mo	N	Nb	FS	FN	FNW
0.07	0.60	6.4	0.02	0.008	8.1	19.2	-	-	-	1.6	3.3	9.1

Typical Mechanical Properties

	R _e (MPa)	R _m (MPa)	A ₅ (%)	CV(J)0°C
	393	583	41	48
Guaranty	min.350	min.500	min.25	

Welding Positions



Approvals

LR	DNV GL	BV	ABS	R.M.R.S	Others
-	*	-	-	-	TÜV, DB

* EN ISO 17633-A - T 18 8 Mn R M 3