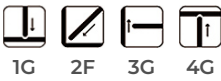


S-307.16

Classification

EN ISO 3581-A E 18 8 Mn R 1 2

Welding Positions



Features

- Low crack sensitivity in high temperature
- Easy to remove slag
- Low spatter
- Good bead appearance

Polarity

AC or DC+

Application Areas

- Stainless steel(18%Cr-8%), 13% Mn steel, Dissimilar welding

Redrying Conditions

350°C (662°F) X 1hr

Typical Chemical Composition of All-Weld Metal (wt%)

C	Si	Mn	P	S	Ni	Cr
0.10	0.90	7.0	0.024	0.010	8.4	19.4

Typical Mechanical Properties of All-Weld Metal

Tensile Strength MPa(ksi)	Elongation (%)	Temperature °C (°F)	Impact Toughness J (ft · lbs)
643(93)	38	-20°(0F)	50(37)

Diameter / Welding Parameters / Packaging

Diameter mm(in)	Length mm(in)	F & HF	V-up, OH	Packaging
2.0 (5/64)	300 (12)	25~55	20~50	PVC - Packet 2.5kg(5.5lbs), Carton 10kg (22lbs)
2.6 (3/32)	300 (12)	50~85	45~80	
3.2 (1/8)	350 (14)	70~115	65~110	
4.0 (5/32)	400 (16)	95~145	85~135	
5.0 (3/16)	400 (16)	135~180	-	

SAW

GMAW

GTAW

FCAW

Metal-cored Wire

SAW Wire

SAW Flux