



# CEWELD AA 307P

**TYPE** All positional Rutile fluxcored stainless steel welding wire for dissimilar welding and buffer layers

**APPLICATIONS** Welding stainless steel to low alloyed steels (dissimilar welds), buffer layers before hard facing, 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. Post weld heat treatment (PWHT) can be applied without any problems.

**CLASSIFICATION**

AWS	A 5.22: ~E307T1-4
EN ISO	17633-A: T 18 8 Mn R M21 1
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** CE

**WELDING POSITIONS**

**TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)**

C	Si	Mn	P	Cr	Ni	Mo	S
0.1	0.7	6.5	0.015	19	9.5	0.3	0.015

**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	-110°C	
As Welded	475	625	40	60	35	180 HB

**REDRYING** 140°C / 24 hr

**GAS ACC. EN ISO 14175** M21