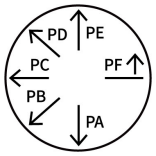
SW-307 Cored

Classification

EN ISO 17633-A/T18 8 Mn P M21/C1 2

Welding Positions



Features

- Good porosity resistance
- Good performance in all positions

Polarity

DC +

Application Areas

- Joining and overlay applications on 13Mn steels
- Cladding carbon steels
- Welding of dissimilar steels (high Mn to carbon steel)

Shielding Gas

100% CO2
Ar+20~25% CO2

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

Shielding Gas	C	Si	Mn	P	S	Cu	Ni	Cr	Mo
100% CO2	0.05	0.8	5.7	0.012	0.008	0.02	8.9	17.9	0.10
Ar + 20% CO2	0.04	0.8	5.2	0.012	0.007	0.02	9.1	17.9	0.10

Typical Mechanical Properties of All-Weld Metal

Shielding Gas	Yield Strength MPa(ksi)	Tensile Strength MPa(ksi)	Elongation (%)	Temperature °C (°F)	Impact Toughness J (ft·lbs)
100% CO2	444 (64)	595 (86)	47	-60 (-76)	67 (49)
Ar + 20% CO2	459 (67)	602 (87)	47	-60 (-76)	62 (46)

Diameter / Welding Parameters / Packaging

Wire Diameter mm(in)	Current (A)	Packaging
1.2 (0.045)	160~220	Spool 5kg (11lbs), 12.5kg (28lbs), 15kg (33lbs), 20kg (44lbs) Drum 100kg (221lbs), 200kg (441lbs), 250kg (551lbs)