INOX B307H

Electrodes MMA [SMAW]

Stainless and high alloyed steels

CLASSIFICATION:	APPROVALS:	APPLICATION:
EN ISO 3581-A : E 18 8 Mn B 42 DIN 8556 : E 188 Mn B 22 AWS A-5.4 : E 307-15 W.Nr. : 1.4370	UDT	Power generation industry Hardfacing and repairing Constructions & Engineering Metallurgy (Steelworks) Mining

- Basic electrode for welding austenitic, acid-resistant steels with yield above 105%.
- It is characterized by very good impact strength and crack resistance.
- It is designed for joining hardened, armored manganese steels with 13% Mn content and difficult-to-weld steels without the need for preheating.
- Recommended for joining stainless and carbon steels with low and medium carbon content.
- The resulting welds can be heat treated without loss of ductility.
- Achieved hardnesses of 200 HV to 450 HV.
- Used as a buffer layer in rock crushers (manganese steels) and in crack repair processes.

Application

Surfacing of rails, track switches, frogs. Perfect as a buffer layer for Hardox steels.

Base material

EN 10088-1-2
X120 Mn 12
X2 CrTi 12
X20 Cr 13
X6 Cr 13
Mixed connections: S235-S355

Typical chemical composition %

C	Si	Mn	Cr	Ni
0,12	0,60	6,00	18,00	8,50

Typical mechanical properties

Yield strength Re [N/mm2]	>350
Tensile strength Rm [N/mm2]	>500
Elongation A5 [%]	>25
Impact energy Kv [J]	>80 J (20°C) /
Coating type	basic
Ferrite content	FN = app. 0
Welding current	
Welding positions	

Redrying	300 - 350°C / 2 h

Welding parameters and packing

ø	Length [mm]	Welding current [A]	Weight of packet [kg]	Weight of carton [kg]	Pcs/1 kg
2,5	300 /	65-70	1,4	8,4	59
3,2	350 /	90-120	1,6	9,6	32
4,0	350 /	115-150	1,5	9,0	20

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