

INOX B307

Electrodes MMA [SMAW]

Stainless and high alloyed steels

CLASSIFICATION: EN ISO 3581-A : E 18 8 Mn B 22 DIN 8556 : E 188 Mn B 22 AWS A-5.4 : E 307-15 W.Nr. : 1.4370	APPROVALS: UDT	APPLICATION: Power generation industry Hardfacing and repairing Constructions & Engineering Metallurgy (Steelworks) Mining
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- Basic electrode for welding austenitic and acid-resistant steels.
- Good impact strength and crack resistance.
- 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 weld 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.
- The use of this weld metal on difficult-to-weld sheets eliminates some of the problems associated with cracking of these steels.

Application

Making dissimilar joints or joining difficult-to-weld materials (Hardox Milux sheets, etc.), joints in Hadfield steel, tool steels, buffer layers, welding steel with high content of sulfur and phosphorus. Welding of armor plates, rails, turnouts, crane wheels, tensioners. Construction of exhaust manifolds, parts of heat exchangers, devices for processing cellulose pulp, papers, textiles. Used for joining or surfacing in dredging or mining machine parts.

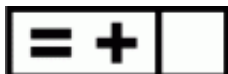
Base material

EN 10088-1-2 EN 10213-4	W.Nr.
X120Mn12	1.3403
X2CrTi12	1.4512
X20Cr13	1.4021
X6Cr13	1.4000
Dissimilar joints: 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 = ok. 0
Welding current	

**Welding positions**

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
2,0	300 /	45-65	1,0	6,0	
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
5,0	350 /	160-210	1,7	10,2	13
6,0	450 /	150-260	6,0	24,0	7

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