

# SW-307NS Cored

Type : Metal Cored

## Conformances

EN ISO 17633-A-T 18 8 Mn M M13/I1

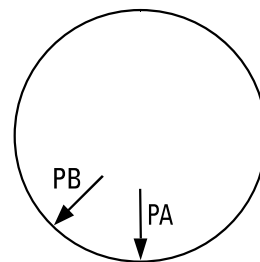
## Applications

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

## Features

- Flat and horizontal fillet position welding
- High deposition rate and efficiency

## Welding Position



## Current

DC +

## Shielding Gas

Ar + 2% O<sub>2</sub>

## Diameter / Packaging

Diameter mm (in)	Spool			Pac		
	5kg (11lbs)	12.5kg (27.6lbs)	15kg (33lbs)	250kg (551lbs)	300kg (661lbs)	350kg (771lbs)
1.2 (0.045)		✓	✓	✓	✓	✓
1.6 (1/16)		✓	✓	✓	✓	✓

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

C	Si	Mn	P	S	Cr	Ni	Mo
0.07	0.6	7.3	0.021	0.008	18.3	8.6	0.1

## Typical Mechanical Properties of All-Weld Metal

TS MPa(lbs/in <sup>2</sup> )	EL (%)	Temp °C(°F)	CVN-Impact Value J (ft-lbs)
610 (88,500)	43	-20 (-4)	106 (78)
		-60 (-76)	71 (52)

## Typical Welding Parameters

Diameter, Polarity Shielding Gas	CTWD mm (in)	Wire Feed Speed m/min (in/min)	Amp. (A)	Volt. (V)	Deposition Rate kg/hr (lb/hr)
1.2mm (0.045 in) DC+					
Ar + 2% O <sub>2</sub>	20 (0.78)	5.5 (216)	190	23~25	4.2 (9.1)
		6.6 (260)	220	25~27	5 (10.9)
		8.1 (320)	250	26~28	6 (13.0)