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DATA SHEET No. S170-004

G-TECH 307

SMAW electrode

Description / Alloy type: Rutile-basic electrode for strong tough austenitic weld metal, for dissimilar joints and buffer layers.

Specifications:

AWS A5.4	**EN ISO 3581-A**
E307-16	E 18 9 Mn Mo R 12

Applications: Mixed welding applications including the welding of CMn, stainless, hardenable and armour steels to themselves or each other.
Resistant to hot cracking is provided by the high manganese content

Materials to be welded: Dissimilar combination of CMn, stainless, hardenable, wear-resistant and armour steels. Also suitable for 13% Mn steel.

Composition: (weight %)

%	C	Mn	Si	Mo	Ni	Cr
Typ	0.09	4.5	0.8	0.6	9.8	19

Welding positions:



Current (DC+): d. 2.5mm **50-80A**; d. 3.2mm **80-110A**; d. 4.0mm **110-150A**; d. 5.0mm **150-200A**;

All-weld properties

Tensile strength [MPa]	> 590
Yield strength [MPa]	> 400
Elongation 5d %	> 20
Impact test [J]	> 60 (at -20°C)

Other products:
MIG, TIG, SAW & FCW Daiko 307
MIG & TIG Daiko 307Si
G-Tech 307B (basic) and 307HR (High Recovery)

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