

Shielded Metal Arc Welding

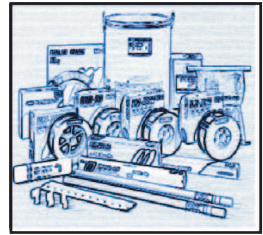
ANU BOND - 307 (E 307 - 15)

AWS:SFA 5.4,E307-15,DIN-8556 E18.8 Mn B 20

Stainless Steel Electrodes

Application :

Ideally suitable for welding of dissimilar steel, 13% Mn steels, Carbon steel. Use for buffer layer prior to hard surfacing , railway liner, marine shaft building , bucket lips etc.



Characteristics on Usage :

It is a rutile coated austenitic stainless steel electrode deposit 18% Cr, 8% Ni, and 6% Mn type of weld metal with 5% ferrite. The weld metal is excellent in crack resistance when welding with unknown steel, dissimilar steel etc. It is all position electrodes giving a very smooth ,quite, stable arc with controllable slag. The weld is of radiographic quality

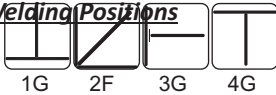
Chemical composition of All-Weld metal (%) as per AWS

C	Mn	Si	S	P	Cr	Ni	Mo
0.04-0.14	3.30-4.75	1.0 Max	0.030 Max	0.040 Max	18.0-21.0	9.0-10.70	0.50-1.50

Mechanical properties of all-weld metal as per AWS

UTS (N/mm ²)	Y.S. (N/mm ²)	Elongation (L=4d) %
590	490	30

Welding Positions



Packaging & Welding Current

SIZE (mm)	KG Per Packet	KG Per Carton	Current (Amps)	In Amps
2.50 x 350	2	12	DC (+)	60-80
3.15 x 350	2	12		80-120
4.00 x 350	2	12		120-160
5.00 x 350	2	12		160-200

