

S-307.16

Type : Rutile

Conformances

EN ISO 3581-A-E 18 8 Mn R 1 2

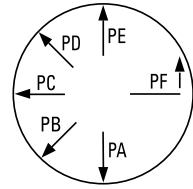
Applications

- Stainless steel(18%Cr-8%), 13% Mn steel, Dissimilar welding

Features

- Low crack sensitivity in high temperature
- Easy to remove slag
- Low spatter
- Good bead appearance

Welding Position



Current

AC or DC +

Redrying Conditions

350°C (662°F) X 1hr

Diameter / Packaging

Diameter mm (in)	Length mm (in)	P.V.C	
		packet 2.5kg(5.5lbs)	carton 10kg(22lbs)
2.6 (3/32)	300 (12)		✓
3.2 (1/8)	350 (14)		✓
4.0 (5/32)	400 (16)		✓
5.0 (3/16)	400 (16)		✓

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S	Cr	Ni
0.09	0.87	6.0	0.025	0.01	19.7	9.0

Typical Mechanical Properties of All-Weld Metal

TS MPa(lbs/in ²)	EL (%)	Temp °C (°F)	CVN Impact Test J (ft-lbs)
643 (93,300)	38	-20 (-4)	60 (37)

Typical Welding Parameters / Amp.(A)

Diameter mm (in)	2.0 (5/64)	2.6 (3/32)	3.2 (1/8)	4.0 (5/32)	5.0 (3/16)
Length mm (in)	300 (12)	300 (12)	350 (14)	400 (16)	400 (16)
F & HF	25-55	50-85	70-115	95-145	135-180
V-up, OH	20-50	45-80	65-110	85-135	-

SMAW

SAW

GMAW

GTAW

FCAW

Non-FERROUS

APPENDIX