

# ES 307-16

Type Rutile-basic

SMAW

E307-16

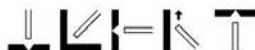
**ESWECO**  
*The Art of Welding*

## Description

ES 307-16 is an austenitic, stainless steel, AC/DC electrode, which deposits a weld metal with a small amount of uniformly distributed ferrite. The tough weld metal has excellent crack resistance, even when welding steels with very poor weldability. Suitable for welding 13Mn steels and steels of this kind to other steels.

### Current

AC, DC+ OCV 65 V



## Classifications

EN 1600	E 18 8 Mn B 1 2
SFA/AWS A5.4	(E307-16)
Werkstoff Nr.	1.4370

## Typical all weld metal composition, %

C	Si	Mn	Cr	Ni	Mo	Cu
0.13	0.9	6.0	18.5	8.5	0.4	<0.5

## Typical mech. Properties all weld metal

Yield stress, MPa	440
Tensile strength, MPa	630
Elongation A5, %	35

### Charpy V

Test temps, °C	Impact values, J
+20	>47
-60	>32

## Welding parameters

Diameter, mm	Length, mm	Welding current, A	Arc voltage, V
2.5	300	60-80	22
3.2	350	90-115	23
4.0	350	100-150	23