

ES 307-25

Type Zirconium-basic

SMAW

E307-25

ESWECO
The Art of Welding

Description

ES 307-25 is a synthetic, high-recovery electrode of the 18Cr8Ni6Mn type for welding dissimilar steels, 13Mn steels, steels with reduced weld-ability and for cladding carbon steels.

Current

DC+, AC OCV 70 V



Classifications

EN 1600	E 18 8 Mn B 8 3
SFA/AWS A5.4	(E307-25)
Werkstoff Nr.	1.4370

Typical all weld metal composition, %

C	Si	Mn	Cr	Ni	Cu
<0.15	1.1	6.0	18.0	9.0	<0.2

Typical mech. Properties all weld metal

Yield stress, MPa	420
Tensile strength, MPa	630
Elongation A4, %	45

Charpy V

Test temps, °C	Impact values, J
+20	70

Ferrite content FN <3

Welding parameters

Diameter, mm	Length, mm	Welding current, A	Arc voltage, V
2.5	350	90-115	25
3.2	450	120-165	34
4.0	450	150-240	40