

ES 307-15

Type Lime-basic

SMAW

E307-15

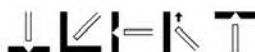
ESWECO
The Art of Welding

Description

ES 307-15 is Austenitic stainless steel electrode producing a weld metal with less than 5% ferrite. The tough weld metal has excellent crack resistance, even when welding steels with very poor weldability. Suitable for joining 12-14% manganese steel to itself or other steels. It is also suitable for buffer layers before hardfacing.

Current

DC+



Classifications

EN 1600
SFA/AWS A5.4

E 18 8 Mn B 4 2
(E307-15)

Typical all weld metal composition, %

C	Si	Mn	Cr	Ni	Mo	Cu
0.11	0.5	6.0	18.5	8.5	<0.5	<0.5

Typical mech. Properties all weld metal

Yield stress, MPa	470
Tensile strength, MPa	605
Elongation A5, %	35

Charpy V

Test temps, °C	Impact values, J
+20	85

Ferrite content	FN <5
-----------------	-------

Welding parameters

Diameter, mm	Length, mm	Welding current, A	Arc voltage, V
2.5	300	50-80	23
3.2	350	70-100	24
4.0	350	100-140	24