

Classifications

EN ISO 3581-A	AWS A5.4
E 18 9 Mn Mo R	E307-17

Characteristics and typical fields of application

Avesta 307 AC/DC is a Mn-alloyed electrode designed for welding dissimilar joints between stainless and mild or low-alloy steels as well as Mn-steels. Avesta 307 offers a crack resistant weld with good mechanical properties.

Corrosion resistance:

Primarily intended for stainless to mild steels connections, but with the same corrosion resistance as 1.4301/ASTM 304.

Base materials

High-alloy electrode for welding stainless steels to carbon steel, low-alloy steel or Mn-steel.

Typical analysis of all-weld metal (wt.-%)

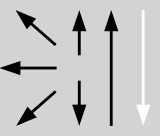
	C	Si	Mn	Cr	Ni	Mo
wt-%	0.06	0.8	4.0	18.9	10.3	0.6

Mechanical properties of all-weld metal

Heat-treatment	Yield strength R _e N/mm ²	Tensile strength R _m N/mm ²	Elongation (L ₀ =5d ₀)	Impact work ISO-V KV J		Hardness
	MPa	MPa	%	+20 °C	-40°C	HB
u	465	605	35	50	-	200

u untreated, as-welded

Operating data

	Polarity: DC (+)	Electrode identification:	ø (mm)	L mm	Amps A
			2.5		50 – 80
			3.25		80 – 120
			4.0		100 – 160
			5.0		160 – 220

Approvals

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