

Standards

TS EN ISO 17633-A : T 18 8 Mn P M21/C1 1
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AWS A5.22 : E307T1-1/-4 (mod.)

**Chemical Composition of
Weld Metal (Typical)**

C	Si	Mn	Cr	Ni
0.10	0.70	6.00	19.0	9.0

Mechanical Properties - (Typical): (With M21 gas)

Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Impact Strength (ISO-V/+20°C)	Elongation (L ₀ =5d ₀) (%)
480	630	50 J	40

Typical Base Material Grades

- High-strength low alloyed and alloyed heat-treatable steels, armor steels, steels including 14 % Mn, ferritic chromium steels, heat-resistaant steels, non-magnetic steels, dissimilar joints and repair welding.

Features and Applications

- ELOXCOR S 307 is rutile fast freezing type flux cored wire
- Work-hardening austenitic deposit in CrNiMn steel modified type 307
- Dissimilar joint, welding of steels of unknown types, armouring steels, buffering joining of 14 %Mn austenitic steels
- Service temperatures from -120°C to +300°C
- Shielding Gas: CO₂ or M21

Welding Positions

Current Type

D.C (+)

Operating Data

Product Code	Diameter (mm) / (inch)		Weight (Kg)	Package Type
6011100006	1.20	0.047"	15	D 300

Approvals: CE, SEPRO