


Technical data sheet <small>080122MBA</small>	Coated SMAW Electrode WA TETRA V 307-E	 Welding Alloys
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CLASSIFICATION

ASME IIC SFA 5.4 / AWS A 5.4: ~E307-16
EN ISO 3581-A: E 18 8 Mn R 3 2

DESCRIPTION AND APPLICATIONS

- Rutile basic coated electrode giving a deposit with good appearance and self-detaching slag
- Non-magnetic work-hardening Cr – Ni – Mn deposit
- Designed for joining and surfacing of manganese steels up to 14% Mn and steels high in sulphur or phosphorus
- Suitable for joints between constructional steels, alloyed and austenitic steels
- Suitable as a buffer layer before hardfacing, and for repairs to worn steels
- Complements Welding Alloys cored wires TETRA S 307-G and TETRA V 307-G

TYPICAL ALL-WELD METAL ANALYSIS [%]

C	Mn	Si	Cr	Ni	Fe
0.1	4.5	1.2	18.0	8.0	Bal.

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2% [MPa]	A ₅ [%]	CVN [J]
600	400	40	+20°C: 70

OPERATING CONDITIONS

Electrode ØxL [mm]	2.5 x 300	3.2 x 350	4.0 x 350	5.0 x 350
Current [A]	75	110	140	160
= +	~ 70V			

Re-drying: if necessary 1h at 250°C.

WELDING POSITIONS

EN ISO 6947: PA, PB, PC, PD, PE, PF, PG
ASME IX: 1F, 1G, 2F, 2G, 3F, 3G, 4F, 4G, 5G

PACKAGING

Electrode ØxL [mm]	2.5 x 300	3.2 x 350	4.0 x 350	5.0 x 350
Weight/box [kg]	4,0	5,0	5,0	5,0

Other packaging and other sizes: please consult us