

SW-307NS Cored

Type : Metal Cored

Conformances

EN ISO 17633-A-T 18 8 Mn M M13/I1

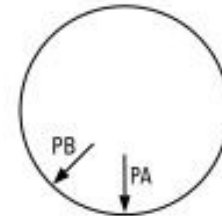
Applications

- Joining and overlay applications on 13Mn steels
- Cladding Carbon steels
- Welding of dissimilar steels (high Mn to carbon steel)

Features

- Flat and horizontal fillet position welding
- High deposition rate and efficiency

Welding Position



Current

DC +

Shielding Gas

Ar + 2% O₂

Diameter / Packaging

| Diameter mm (in) | Spool | | | Pac | | |
|---------------------|-------------|------------------|--------------|----------------|----------------|----------------|
| | 5kg (11lbs) | 12.5kg (27.6lbs) | 15kg (33lbs) | 250kg (551lbs) | 300kg (661lbs) | 350kg (771lbs) |
| 1.2 (0.045) | | ✓ | ✓ | ✓ | ✓ | ✓ |
| 1.6 (1/16) | | ✓ | ✓ | ✓ | ✓ | ✓ |

Typical Chemical Composition of All-Weld Metal (%)

| C | Si | Mn | P | S | Cr | Ni | Mo |
|------|-----|-----|-------|-------|------|-----|-----|
| 0.07 | 0.6 | 7.3 | 0.021 | 0.008 | 18.3 | 8.6 | 0.1 |

Typical Mechanical Properties of All-Weld Metal

| TS MPa(lbs/in ²) | EL (%) | Temp °C(°F) | CVN-Impact Value J (ft-lbs) |
|---------------------------------|-----------|-----------------------|--------------------------------|
| 610 (88,500) | 43 | -20 (-4) -60 (-76) | 106 (78) 71 (52) |

Typical Welding Parameters

| Diameter, Polarity Shielding Gas | CTWD mm (in) | Wire Feed Speed m/min (in/min) | Amp. (A) | Volt. (V) | Deposition Rate kg/hr (lb/hr) |
|-------------------------------------|-----------------|-----------------------------------|-------------|--------------|----------------------------------|
| 1.2mm (0.045 in) DC+ | | | | | |
| Ar + 2% O ₂ | 20 (0.78) | 5.5 (216) | 190 | 23-25 | 4.2 (9.1) |
| | | 6.6 (260) | 220 | 25-27 | 5 (10.9) |
| | | 8.1 (320) | 250 | 26-28 | 6 (13.0) |

| Diam. | 15 kg Spool |
|-------|-------------|
| 1.2mm | HKSW307NS12 |

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