

## Cored Wires Stainless and Heat resistant steels

Fluxinox 307-PF is an alloyed rutile flux cored wire with a fast-freezing slag for crack-resistant joining and surfacing of heat treatable steels, armour plates, corrosion resisting steels and high manganese steels. It is also suitable for joining austenitic stainless steels to unalloyed steels. The weld metal is suitable for operating temperatures up to 300 °C, and is non-scaling up to 850 °C. It is highly rust and corrosion resistant, and will harden by cold working. Due to its fast-freezing slag, Fluxinox 307 PF is well-suited for welding in the horizontal (PD), overhead (PE) and vertical-up (PF) positions.

Classification	
AWS	A5.22: E 307T1-G
EN	12073: T 18 8 Mn P M 1 / T 18 8 Mn P C 1

Approvals	Grades
	GL

see Appendix, Classification Society Approvals, for details pag. 521

### Analysis of all-weld metal (Typical values in %)

C	Mn	Si	P	S	Cr	Ni	Mo	Nb	Cu	N	Ferrite
≤ 0.10	6.50	0.70	-	-	19	8.50	-	-	-	-	-

### All-weld metal Mechanical Properties

Heat Treatment	Yield Strength N/mm <sup>2</sup>	Tensile Strength N/mm <sup>2</sup>	Elongation A5 (%)	Impact Energy ISO - V (J) + 20 °C	Hardness
As Welded	≥ 350	≥ 590	≥ 30	≥ 40	-

Gas test: Acc. To EN 439: M21(Arcal 21-Atal 6)

**Shielding Gas:** Acc. To EN 439: M21(Arcal21-Atal6) or C1(Arcal 2)

### Materials

Armour plate; Dissimilar Steels  
X120Mn12 (1.3401)

### Storage

Keep dry and avoid condensation

### Current condition and welding position

DC+



**Packaging data:** K300 kg. 16

Diameters	1,2					
-----------	-----	--	--	--	--	--