



HILCO HILCHROME 307R

Stick electrodes – stainless steel – special purpose

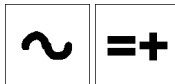
AWS A5.4: E307-16 (mod.)

EN ISO 3581-A: E 18 8 Mn R 1 2

Werkstoffnr. 1.4370

Coating type:
Rutile-basic

Current:



Welding positions:



Hilchrome 307R is our rutile basic coated electrode for joining dissimilar steels and difficult-to-weld steels. Typical applications include joining 14Mn steels, spring steels, tool steels, and high carbon steels. This electrode is recommended for buffer layers prior to surfacing. The deposit weld metal features strain hardenability, excellent cavitation resistance, thermal shock resistance, crack resistance and scaling resistance up to 850°C. Hilchrome 307R is a core wire alloyed all-current type (AC/DC).

Base materials to be welded:

- Armour plate
- Hardenable steels incl. DFTW-steels
- Non-magnetic austenitic steels
- Work hardening austenitic manganese steels
- Heat resisting ferritic chromium steels
- Dissimilar joining

Applications:

- Repair & Maintenance
- Transport & Lifting Industry
- Process Industry

Chemical composition, wt. % weld metal – typical:

C	Mn	Si	Cr	Ni
0,10	7,0	0,60	18,5	8,0

Mechanical properties, weld metal – typical:

Condition	0,2% Yield strength MPa	Tensile strength MPa	Elongation Lo=5d - %	Impact Values ISO-V J
As welded	≥ 390	≥ 620	≥ 35	20°C ≥ 70

Packaging and welding data:

Dia. mm.	Length mm.	Weight (kgs) 1000 pcs.	Current A
3,2	350	34,6	65-105
4,0	350	51,1	110-140