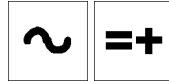


Coating type:

Rutile-basic

Arc voltage: 50V

Current:



Tip colour:

-

Welding positions:



Printing:

Hilchrome 307R / E307-16

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, high carbon steels. The 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

Equivalent product in alternative welding process:

SMAW	GMAW	FCAW	GTAW	SAW	Gas welding / brazing
-	-	-	-	-	-

Chemical composition, wt. % weld metal – typical:

C	Mn	Si	S	P	Cr	Ni	Mo	Cu	Nb	V	Al
0,10	6,50	0,70	≤ 0,030	≤ 0,030	18,8	8,80					

Mechanical properties, weld metal – typical:

Condition	0,2% Yield strength MPa	Tensile strength MPa	Elongation Lo=5d - %	Impact Values ISO-V J
As welded	≥ 500	≥ 650	≥ 30	+20°C ≥ 80

Packaging and welding data:

Dia. mm.	Length mm.	Weight (kgs) 1000 pcs.	Current A
3,2	350	34,6	80-120
4,0	350	51,1	100-160