

# Flux Cored Wire for Stainless Steel

## KFW-307

### Classification

Shielding Gas:

CO<sub>2</sub> or Ar+20%CO<sub>2</sub>

AWS	E307T1-1/4	—
JIS	Z3323	TS307-FB0
EN	17633-A	C1 M12 M21 Z
GB	T 17853	E307T1

### Applications and Features

- (1) Weld metal is 20%Cr-9%Ni-6%Mn.
- (2) It has good crack resistance.
- (3) This wire's relatively high manganese content helps reduce the chance of weld metal cracking in dissimilar metal welding.

### Welding Instruction

- (1) Use Ar blend with 1~2%O<sub>2</sub> for high current, spray transfer welding.
- (2) Use Ar blend with 1~2%CO<sub>2</sub> for low current, short-circuit transfer welding.
- (3) For other instructions, please refer to Appendix D.
- (4) For extra information, please refer to Appendix F.

### Typical Chemical Composition of Weld Metal (wt %) (Shielding Gas : Ar+2%O<sub>2</sub>)

C	Si	Mn	P	S	Cr	Ni
0.11	0.65	6.11	0.007	0.01	18.85	8.91

### Typical Mechanical Properties of Weld Metal

(Shielding Gas : Ar+2%O<sub>2</sub> PWHT 1050°Cx4Hr, 630°Cx4Hr)

Tensile Strength N/mm <sup>2</sup> (kgf/mm <sup>2</sup> )	Yield Strength N/mm <sup>2</sup> (kgf/mm <sup>2</sup> )	Elongation %
620	410	38

### Size and Suggested Operating Range (DC+)

Operating range	Diameter (mm)	0.8	0.9	1.0	1.2	1.4	1.6	
		Ar+1~2%CO <sub>2</sub>	Amp	—	60~140	80~160	100~210	—
		Volt	—	15~21	16~22	17~22	—	—
Ar+1~2%O <sub>2</sub>	Amp	—	170~260	180~280	200~300	210~320	220~330	
	Volt	—	24~30	24~30	24~30	24~32	24~32	