



AWS A5.4 E307- 15

EN ISO 3581-A:E

AK E307-15

Description: E307-15 is a basic coated multipurpose stainless steel electrode producing a weld metal of 18Cr - 9Ni - 4.75Mn. The weld metal has excellent crack resistance and has good scaling resistance up to 850 °C. Ideal for joining ferritic to austenitic steels, armour plates, austenitic manganese steels, heat resistant steels, dissimilar materials, for buffer layers etc.

Typical Chemical Composition(%):

	C	Si	Mn	S	P	Ni	Mo	Cr	Cu
Requirement	0.04-0.14	1.0	3.3-4.75	0.03	0.04	9.0-10.70	0.5-1.5	18-21.5	0.75
Actual Result	0.084	0.40	4.12	0.01	0.025	9.63	0.81	19.51	0.04

Typical Mechanical Properties:

	Tensile strength (MPa)	Yield Stress (MPa)	Elongation (%)	Impact Values (J)
Requirement	≥ 590		≥ 30	
Actual Result	650		35	