

GFC 307

IDENTIFICATION

GFC 307, E307T-1

CLASSIFICATION

AWS/SFA 5.22: E307T-1

DESCRIPTION

GFC 307 is a metal cored wire with a hot cracking resistant austenitic weld metal. The weld metal has a excellent crack resistance, even when welding steels having very poor weldability. This wire is designed for welding dissimilar steels. e.g. Mn steels with good weldability and for cladding carbon steels. Can also be used as a buffer layer prior to hard surfacing.

WELD METAL ANALYSIS (RANGE) %

C	Cr	Ni	Mn	Cu	Si	S	P	Mo
0.13 max	18.0 - 20.5	9.0 - 10.5	3.3 - 4.75	0.75 max	0.81 max	0.03 max	0.03 max	0.5 - 1.5

MECHANICAL PROPERTIES (RANGE)

UTS (MPa)	EL (%) (L=4D)	CVN Impact Value	
594 min	30 min	Temp	Joules
		-20°C	80

TYPICAL APPLICATIONS

- For welding dissimilar steels.
- 13% Mn steels with good weldability.
- For cladding carbon steels.

USAGE

- The shielding gas should be used Ar or Ar + 2-5% O2 for welding.
- Welders for solid wire can be used but as wire is softer than solid wire.
- Pay full attention to adjust feeding roller and do not tighten them excessively.

PACKING PARAMETERS

Size (mm)	Current Condition (DC+)	Weight / Spool (kg)
1.2	130 - 280	15
1.6	200 - 350	15