SUPRANOX RS 307

TOP FEATURES

- Excellent weldability with a spatter free arc
- Self-releasing slag.
- Very smooth bead appearance.

CLASSIFICATION

AWS A5.4	E307-16 *
EN ISO 3581-A	E 18 8 Mn R 12 E Fe10
EN 14700	E Fe10

* Nearest classification

CURRENT TYPE

AC, DC+

WELDING POSITIONS

All position, except vertical down

APPROVALS

TÜV	DB
+	+

CHEMICAL COMPOSITION (WEIGHT %), TYPICAL, ALL WELD METAL

C	Mn	Si	Cr	Ni
0.12	5	1	18	9

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Condition*	0.2% Proof strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J) +20°C	Hardness	
						HRc	HB
AWS A5.4	AW	not specified	≥590	≥30	not specified	not specified	not specified
EN ISO 3581-A	AW	≥350	≥500	≥25	not specified	not specified	not specified
EN 14700	AW	not specified	not specified	not specified	not specified	180-200	38-42
Typical values	AW	450	650	35	110	not specified	not specified

* AW = As welded

OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
2.5 x 300	50-80
3.2 x 300	80-130
4.0 x 350	120-160

PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
3.2 x 300	VPMD	60	1.6	W000258460
4.0 x 350	VPMD	40	2.0	W000258461

TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application

Safety Data Sheets (SDS) are available here:

Subject to Change – The information is accurate to the best of our knowledge at the time of printing.
Please refer to www.lincolnelectric.eu for any updated information.