

MIDALLOY MASTERCOR E307T0-G FLUX-CORED WIRE

CLASSIFICATION

- 1 AWS 5.22 Class E307T0-G / ASME SFA 5.22 Class E307T0-G

DESCRIPTION

- 1 MIDALLOY MASTERCOR E307T0-G is a flux cored wire used to weld and overlay high manganese steels. In addition it is an excellent choice to weld manganese steels to carbon steels.
- 1 Midalloy Mastercor E307T0-G has excellent slag removal and runs with a spatter free globular transfer. The weld deposit has no ferrite and care must be taken to avoid hot cracks. This is accomplished by low heat input and making "convex" bead profiles.

APPLICATIONS

- 1 Base material plates such as armor plate, manganese steel and wear plates are welded to themselves as well as to carbon and alloy steels with MIDALLOY MASTERCOR E307T0-G.
- 2 MIDALLOY MASTERCOR E307T0-G may be a better choice of buffer layer or buttering alloy under hard facing alloys.

TYPICAL CHEMISTRY

C	Mn	Si	P	S	Ni	Cr	Mo
0.10	6.8	0.8	.03	.02	9.1	19.2	0.5

The Mn content is outside the AWS classification limit for E307T1-1,3,4

TYPICAL MECHANICAL PROPERTIES

TENSILE STRENGTH	91,000 PSI
YIELD STRENGTH	61,000 PSI
ELONGATION IN 2"	40%
CHARPY	50 FT-LB. @ 72°F, 20 FT-LB. @ -120°F

WELDING PARAMETERS

DIAMETER	AMPERAGE	VOLTAGE	SHIELDING GAS
.045"	120-200	24-28	100% CO ₂ or
1/16"	150-250	25-30	75%Ar-25% CO ₂

Note: When welding high manganese steels be sure to keep the manganese steel under 500°F at all times. Air or water-cooling may be used as long as weld area is kept dry.

STANDARD PACKAGING

- 1 25 lb. spool