MIDALLOY MASTERCOR E307T1-1/4 AP FLUX-CORED WIRE

CLASSIFICATION
- MIDALLOY MASTERCOR E307T1-1/4 meets AWS/ASME 5.22 Classification E307T1C and E307T1M
- UNS# W30731

DESCRIPTION
- MIDALLOY MASTERCOR E307T1-1/4 is an "All Position" flux-cored welding wire particularly suited for general fabrication of large components. The weld deposits contain little to no ferrite. Care must be taken to avoid hot cracks. The best techniques to use are low heat input and making "convex" bead profiles. Weld deposits of Midalloy Mastercor E307T1-1/4 will work harden in service.

APPLICATIONS
- For joining and overlay applications on manganese steels
- Attaching (welding) wear plates to carbon and alloy steels like T1.
- Welding carbon steel to stainless steel for high temperature applications(above 600°F).
- Excellent slag removal and high operator appeal.

TYPICAL CHEMISTRY

C	Mn	P	S	Cr	Mo	Cu	Si	Ni
0.10	4.0	0.03	0.02	19.2	0.55	0.20	0.75	9.1

TYPICAL ALL WELD METAL MECHANICAL PROPERTIES

TENSILE STRENGTH	91 KSI
YIELD STRENGTH	61 KSI
ELONGATION	40%
IMPACTS @ 70°F	50 FT-LBS
IMPACTS @ -120°F	20 FT-LBS

WELDING PARAMETERS

DIAMETER	1/16"	.045"
SHIELDING GAS	25%CO_2 / 75%ArOR 100% CO_2	25% CO_2 / 75% Ar or 100% CO_2
AMPS & VOLTAGE SETTINGS-LOW V-UP	26V / 180 AMPS	24V / 120 AMPS
HIGH	28V / 250 AMPS	28V / 200 AMPS

- Electrode Stickout: 5/8 – 3/4
- Contact tip – slightly below gas nozzle
- DC Reversed Polarity
- Gas Flow 35-45 CFH

STANDARD PACKAGING
- 33 lb. spool
- Available sizes .045" and 1/16"

12/22/10

Midalloy