

AUSTINITIC STAINLESS STEEL ELECTRODE

RASI E 307R-16

TECHNICAL SPECIFICATION SHEET



CHARACTERISTICS

RASI 307R-16 is a versatile austenitic Stainless Steel electrode with 19Cr-9Ni-6Mn. It has a high deposition efficiency. The weld Metal is characterised by exceptional crack resistance and high deformability. The stable austenitic microstructure does not suffer any sigma phase formation. Weld metal tends to work Harden through deformation by impact and there by gains considerable abrasion resistance.

APPLICATIONS

RASI E 307R-16 Is a universal austenitic stainless steel type, suitable for variety of application. Suitable for joining of austenitic steel to ferritic steels and it can be employed for service temperature up to 5500C, Steels resistance to scaling up to 8500C. Joining of austenitic Mn steels to other steels. In the reclamation of worn out parts can be used for buffer layer and hard facing

CLASSIFICATIONS

AWS A/SFA 5.4 E 307- 16
IS : 5206 E 18.8MnR26

CHEMICAL COMPOSITION OF ALL WELD METAL

Carbon - 0.12%	Silicon - 0.90%
Manganese - 3.50%	Sulfur - 0.03%
Phosphorus - 0.03%	Cr - 18 - 22%
Mo - 0.50%	Ni - 9 - 11%
Cu - 0.75%	

Note: Single Values shown above are maximum

MECHANICAL PROPERTIES OF ALL WELD METAL

Tensile Strength (N/mm²) - 620 - 660
WELD METAL HARDNESS
AS DEPOSITED - 200BHN
AS WORK HARDNESS - 500 - 550 BHN.

WELDING CURRENT : DC± / AC 50 V

Ø 2.50 mm - 60 - 90 Amps
Ø 3.15 mm - 75 - 100 Amps
Ø 4.00 mm - 100 - 140 Amps
Ø 5.00 mm - 1150 - 175 Amps.

***FOR APPROVALS AND CERTIFICATIONS KINDLY CONTACT :- info@rasielectrodes.com**

storage - Store in warm and dry place. If damped re dry at 300°C for 1 hour.

*All statements, information and data given are believed to be accurate and reliable but are presented without guarantee, warranty or responsibility of any kind, expressed or implied.

www.rasielectrodes.com

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