

TASETO Welding Materials

Stainless Steel Electrodes

For Shielded Metal Arc Welding

RNY307

● Applicable Specification

JIS Z 3221 ES307-16
AWS A5.4 E307-16

● Identification Color

End Face: Purplish Red
Side Face:—

● Applications and Characteristics

TASETO RNY307 has a fully austenitic structure, and its all weld metal has little hot cracking susceptibility. It is used for welding of non-magnetic materials or materials, which are used at low temperatures, as well as for welding of low alloy steel with poor weldability. RNY307 is also suitable for overlay welding of impeller to prevent cavitations.

RNY307 is a lime-titania type covered electrode suitable for positional welding.

● Notes on Usage

* Dry the electrode at 150°C to 200°C for 60 minutes before use.

* Remove oil and dust from the surface to be welded.

● Chemical Composition of All Weld Metal (%)

	C	Si	Mn	P	S	Ni	Cr	Mo	Cu
Typical	0.061	0.41	4.61	0.022	0.002	9.37	19.95	1.05	0.11

● Mechanical Properties of All Weld Metal

	Tensile Strength (MPa)	5D Elongation (%)	Absorbed Energy at 0°C (J)
Typical	650	42.0	95

● Typical Tensile Strength of All Weld Metal after PWHT

PWHT	Tensile Strength (MPa)
650°C×2h AC.	570
750°C×2h AC.	601
850°C×2h AC.	571

● Other Properties of All Weld Metal

* Typical Ferrite Content : 0% (Schaeffler's Diagram)

● Sizes Available, Recommended Currents (AC or DCEP)

Size (mm)	Length (mm)	Welding Current (A)	
		Flat	Vertical, Overhead
2.6	300	50~90	45~80
3.2	350	80~120	65~110
4.0	350	110~150	85~135
5.0	350	150~200	—