

BASINOX 307 is a basic-coated MMA electrode suitable for joining, buffering, maintenance and repairing. BASINOX 307 is used for welding of mild, stainless, hardenable, and armour steels to themselves or each other with or without preheat, buffering prior to hardsurfacing. Good corrosion, wear resistance and work hardening. The hardness of the all-weld metal is ~180-200HB, which work hardens to ~280-300HB under impact load. Excellent mechanical properties, high crack resistance with maximum service temperature up to 850°C. Easy striking and restriking and smooth arc. Slag solidifies quickly, covers the weld uniformly and BASINOX 307 is well-suited for positional welding.

Classification	
EN	14700: E Fe10
EN	3581-A: E 18 8 Mn B 22
AWS	A5.4: ~E 307-15

Approvals	Grade
DB	●
TÜV	●

CE

Chemical analysis (Typical values in %)

C	Mn	Si	P	S	Cr	Ni	Ferrite
≤0.15	4.5-7.5	≤0.9	≤0.035	≤0.025	18-21	7-11	5-10

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation A5 (%)	Impact Energy ISO - V (J)
				+20 °C
As Welded Unbehandelt	≥ 350	≥ 500	≥ 30	≥ 47

Materials

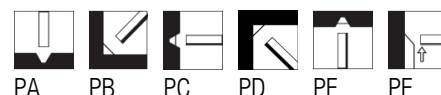
Difficult to weld steels, low alloyed to stainless steels, armour plates, hardsurfacing

Storage

Keep dry and avoid condensation.
Re-dry 250-300°C for 1 hour, 5 times max.

Current condition and welding position

DC+



Packaging data

Diam. (mm)	Length (mm)	Current (A)	Approx. weightn(kg/1000)	VPMD	
				PC	Code
2.5	300	60-75	18.95	95	W000380922
3.2	350	85-110	35.0	60	W000380558
4.0	350	95-145	52.5	40	W000380559
5.0	350	130-160	83.37	25	W000380561