



307

"Magnamatic" Electrode for Mild Steel

SUPERTECH
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Complete Welding Solutions

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MAGNA 307

"Magnamatic" Electrode for Mild Steel

- *Provides extraordinary weldability – engineered for ease of use.*
- *Ideal for "on-site" and restrictive position use.*
- *Will not spatter – even on wet surfaces.*

**TRUST
MAGNA
FOR** *Ease of Application
Wide Versatility
Outstanding Physical
Properties*

MAGNA INDUSTRIAL CO. LIMITED
— Total Quality Maintenance



SPECIAL FEATURES

Magna 307 "Magnamatic" Electrode for Mild Steel makes every welder look like a seasoned professional.

- **Magna 307** is quality engineered for ease of use to provide extraordinary weldability.
- **Magna 307** is ideal for construction and repair work, particularly "on-site" and restrictive and off-position use.
- **Magna 307** offers optimum performance and will not spatter – even on wet surfaces.

OUTSTANDING PROPERTIES

Magna 307 is the superior electrode for mild steel that features:

- High tensile strength up to 84,000 p.s.i.
- High yield strength up to 66,000 p.s.i.
- Welds up to 50% faster than ordinary electrodes.
- Provides up to 80% more length deposit.
- Automatic slag removal.

USE FOR

Magna 307 (for AC & DC) is the right choice for welding all mild steels



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MAGNA 307

DESCRIPTION:

Magna 307 is an all position alloy steel electrode developed for construction and repair work on mild steels, particularly 'on site' and in restrictive positions.

Magna 307 has evolved after extensive laboratory research and field testing and offers optimum quality and performance on a wide range of various job conditions.

High Quality Characteristics:

The outstanding properties of Magna 307 will offer a tensile strength of up to 59 Kg. mm² (84,000 p.s.i.) thus ensuring joints of maximum strength.

Ignition and re-ignition qualities are exceptionally good and the ease at which Magna 307 can be applied is remarkable.

Such characteristics will ensure high quality welds, even under adverse conditions, or where the welder has had limited experience.

Coating Chemistry:

Special materials which are easily ionized have been incorporated in the Magna 307 flux coatings.

The ease of ionization permits the establishing and maintenance of the arc at lower welding currents and low open-circuit voltages. Such a characteristic is of great assistance when welding thin sections as the use of low welding currents will prevent burn-through.

The Magna 307 coating forms a 'crucible action' at the tip of the electrode which controls the molecular velocity and stabilizes the arc. The crucible action also generates gases by pyrolysis of the coating together with ions and metal vapours of the core wire, thus producing a fine metallic spray transfer.

The protective gases which exclude atmospheric contaminants from the molten weld metal are highly effective thus ensuring sound, high strength welds.

The slag coating is extremely easy to remove and in most cases is self lifting. This will greatly save valuable time and effort.

APPLICATION

Magna 307 is applied with either a short arc or with the touch weld technique. AC or DC equipment can be used. When DC is used, reverse or straight polarity can be incorporated.

The electrode should be held at an angle of 30-40 degrees to the direction of travel when welding in the downhand position.

For vertical welds, the electrode should be held at approximately 10 degrees from the horizontal for vertical up, and for vertical down it should be held at an approximate angle of 45 degrees from the horizontal.

Recommended Amperages:

Metric	Inches	Gauge	Setting
4.0 mm.	5/32	8	65 - 190 amps
3.2 mm.	1/8	10	50 - 160 amps
2.4 mm.	3/32	12	30 - 115 amps

For more details :

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