

LNT/LNM 304L

Stainless solid wire

Classification

AWS A5.9-93 : ER308L
EN 12072-99 : W 19 9 L / G 19 9 L

General description

Solid wire with extra low carbon for welding austenitic CrNi-steels
High resistance to intergranular corrosion and oxidizing environments

Shielding gases (acc. EN 439)

GTAW	I1	Inert gas Ar (100%)
GMAW	M12	Mixed gas Ar+ >0-5% CO ₂
GMAW	M13	Mixed gas Ar+ >0-3% O ₂

Approvals

	TÜV
GTAW	+

Chemical composition (w%), typical, wire / rod

C	Mn	Si	Cr	Ni	Mo
0.010	1.6	0.5	20	10	0.2

Mechanical properties, typical, all weld metal

	Process	Shielding gas	Condition	0.2% Proof strength	Tensile strength	Elongation	Impact ISO-V(J)	
				(N/mm ²)	(N/mm ²)	(%)	+20°C	-196°C
Typical values	GTAW	I1	AW	390	590	35	120	50
	GMAW	M12	AW	390	590	35		

Materials to be welded

Steel grades	EN 10088-11-2	EN 102 13-4	W.Nr.	ASTM/ACI A240/A312/A351	UNS	
Extra low carbon C < 0.03%	X2CrNi19 11		1.4306	(TP)304 L	S30403 J92500	
	X2CrNiN18 10		1.4311	(TP)304LN	S30453	
Medium carbon C > 0.03%	X4CrNi18 10		1.4301	302, 304 (TP)304	S30400 S30409	
			GX5CrNi19 10	1.4308	CF-8	J92600
Ti-,Nb stabilized	X6CrNiTi18 10		1.4541	(TP)321	S32100/ S32109	
				(TP)321H	S32109	
	X6 CrNiNb 18 10		1.4550	(TP)347	S34700	
			GX5 CrNiNb 19 10	1.4552	CF-8C	J92710

Packaging

Process	Unit	Sizes (mm)				
		1.0	1.6	2.0	2.4	3.2
GTAW	5 and 10 kg tube		X	X	X	X
GMAW	15 kg spool BS300	X				

Other sizes and packaging on request

LNT/LNM 304L: rev. EN 15