

LNT/LNM 304LSi

Stainless solid wire

Classification

AWS A5.9-93	: ER308LSi
EN 12072-99	: W 19 9 LSi / G 19 9 LSi

General description

Solid wire with extra low carbon for welding austenitic CrNi-steels
With increased silicon for improved wettability

Shielding gases (acc. EN 439)

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

Approvals

	ABS	BV	CTL	DB	DNV	GL	LR	TÜV
GTAW	ER 308LSi		+	+	308L		+	+
GMAW	ER308LSi	308L	+	+	308L	4306S	304L S	+

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

C	Mn	Si	Cr	Ni	Mo
0.010	1.7	0.8	20	10	0.2

Mechanical properties, typical, all weld metal

	Process	Shielding gas	Condition	0.2% Proof strength (N/mm ²)	Tensile strength (N/mm ²)	Elongation (%)	Impact ISO-V(J)		
							+20°C	-20°C	-196°C
Typical values	GTAW	I1	AW	390	590	36	120		50
	GMAW	M12	AW	420	570	45		85	55

Materials to be welded

Steel grades	EN 10088-1/-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
			1.4311	CF-3	J92500
Medium carbon C > 0.03%	X2CrNiN18 10		1.4311	(TP)304LN	S30453
				302, 304	S30400
Ti-,Nb stabilized	X4CrNi18 10		1.4301	(TP)304	S30409
				CF-8	J92600
Ti-,Nb stabilized	X6CrNiTi18 10	GX5CrNi19 10	1.4308	CF-8	J92600
			1.4541	(TP)321	S32100
				(TP)321H	S32109
			1.4550	(TP)347	S34700
	X6 CrNiNb 18 10		1.4552	CF-8C	J92710
		GX5 CrNiNb 19 10			

Packaging

Process	Unit	Sizes (mm)							
		0.8	1.0	1.2	1.6	2.0	2.4	3.2	
GTAW	2 and 10 kg tube		X	X	X	X	X	X	
GMAW	5 kg spool S200		X						
	15 kg spool BS300	X		X	X	X			

Other sizes and packaging on request

LNT/LNM 304LSi: rev. EN 15

LINCOLN
ELECTRIC

GMAW/GTAW