LNT/LNM 4439 Mn

Stainless solid wire

Classification

EN 12072-99 : W 18 16 5 N L* / G 18 16 5 N L*

* Nearest classification

General description

Solid wire for welding AISI 317L, 317LN or equivalent stainless steels
For welding 316L if increased molybdemum content is important
High resistance to pitting, intergranular and stress corrosion
Fully austenitic weld metal

Shielding gases (acc. EN 439)

GTAW	I1	Inert gas Ar (100%)
GMAW	M12	Mixed gas Ar+ >0-5% CO_2
	M13	Mixed gas Ar+ >0-3 O2

Approvals

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

C	Mn	Si	Cr	Ni	Mo	N
0.02	7	0.7	19.1	16.9	4.6	0.15

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	-120°C	-196°C
Typical values	GTAW	I1	AW	440	650	35			80
	GMAW	M12	AW	410	620	30	120	80	50

Materials to be welded

Steel grades	EN10088-1/-2	EN 102 13-4	W.Nr.	ASTM/ACI	UNS
Fully	X2 CrNiMoN 17-11-2		1.4406	(TP)316LN	S31653
austenitic	X2 CrNiMoN 17-13-3		1.4429	(TP)316LN	S31653
CrNiMo-	X2 CrNiMo 18-14-3		1.4435	(TP)316L	S31603
corrosion	X2 CrNiMo 18-15-4		1.4438	317L	S31725
resistant steel	X2 CrNiMoN 17-13-5		1.4439	317LN	S31726
	G-X2 CrNiMoN 17-13-4	GX2 CrNiMo 17-13-4	1.4446		
	G-X6 CrNiMo 17-13	GX6 CrNiMo 17-13	1.4448		

Packaging

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

Other sizes and packaging on request

LNT/LNM 4439 Mn: rev. EN 15