

LNT 307

CLASSIFICATION

AWS A5.9 - ER307* * Nearest classification
ISO 14343-A - W 18 8 Mn

GENERAL DESCRIPTION

Solid rod for welding austenitic and ferritic stainless steels with difficult weldability
Often used as a buffer layer for hardfacing applications

SHIELDING GASES (ACC. ISO 14175)

I1 Inert gas Ar (100%)

APPROVALS

TÜV	DB
+	+

CHEMICAL COMPOSITION (W%) TYPICAL WIRE

C	Mn	Si	Cr	Ni
0.07	7.1	0.8	18.6	8.0

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Shielding gas	Condition	0.2% proof strength (N/mm ²)	Tensile strength (N/mm ²)	Elongation (%)	Impact ISO-V(J) +20°C
Typical values	I1	AW	400	650	35	100

MATERIALS TO BE WELDED

Various steel grades, such as:

- Armour plate
- Hardenable steels including steels difficult to weld
- Non-magnetic steels
- Work hardening austenitic manganese steels
- Dissimilar joints (CMn-steels to stainless steels)
- Exhaust systems

PACKAGING AND AVAILABLE SIZES

	Diameter (mm)	1.6	2.0	2.4
Unit :	5 kg tube	X		X
	10 kg tube		X	X

Other sizes and packaging on request

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