LNT 307

CLASSIFICATION

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

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

С	Mn	Si	Cr	Ni
0.07	7.1	0.8	18.6	8.0

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Shielding		0.2% proof strength	Tensile strength	Elongation	Impact ISO-V(J)
	gas	Condition	(N/mm²)	(N/mm ²)	(%)	+20°C
Typical values	11	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	Х		Х
	10 kg tube		Х	Χ

Other sizes and packaging on request

LNT 307 rev. EN 22



All information in this data sheet is accurate to the best of our knowledge at the time of printing. Please refer to www.lincolnelectric.eu for any udpated information. Fumes: Material Safety Data Sheets (MSDS) are available on our website.