

Lincolnweld® P3000™

Stainless • EN 760 – S A CS 2

Key Features

- ▶ A chromium alloyed flux for strip cladding where ferrite content of at least 4 FN is desired with 309L strip on carbon steel in one layer
- ▶ Low dilution into the base material being surfaced
- ▶ Achieves high alloy and low carbon content deposit even in the first layer of cladding
- ▶ High ferrite content (4FN), which is desired with 309L strip on carbon steel in one layer

Typical Applications

- ▶ Austenitic stainless strips including EQ308, EQ309, EQ347 and EQ309Cb
- ▶ Low carbon steels including EQ308L, EQ309L and EQ316L

Packaging

44 lb (20 kg)
Hermetically Sealed Pail ED033160

DEPOSIT COMPOSITION⁽¹⁾

	%C	%Mn	%Si	%Cr	%Ni	%Mo	Ferrite Number
AWS Strip Requirements, EQ309L⁽²⁾	0.03 max.	1.0 - 2.5	0.30 - 0.65	23.0 - 25.0	12.0 - 14.0	0.75 max.	Not Specified
Strip Composition	0.01	1.8	0.35	23.8	13.7	0.10	14
One Layer Cladding on A516-70	0.06	0.9	0.90	21	12.1	0.10	5
Second Layer Cladding	0.02	0.9	1.10	23.2	13.6	0.10	9

Lincolnweld® P4000™

Stainless • EN 760: S A AF 2; EN 760: S A FB 2

Key Features

- ▶ A neutral flux designed for cladding applications using the electroslag process with stainless steel or nickel-based alloy strip electrodes

Typical Applications

- ▶ For strip cladding using the electroslag process

Packaging

44 lb (20 kg)
Hermetically Sealed Pail ED033161

DEPOSIT COMPOSITION⁽¹⁾

	%C	%Mn	%Si	%Cr
AWS Strip Requirements, EQ309L⁽²⁾	0.03 max.	1.0 - 2.5	0.30 - 0.65	23.0 - 25.0
Strip Composition	0.01	1.7	0.35	23.9
One Layer Cladding on A516-70	0.03 - 0.04	1.3 - 1.4	0.50	19.9 - 21.9
	%Ni	%Mo	Ferrite Number	
AWS Strip Requirements, EQ309L⁽²⁾	12.0 - 14.0	0.75 max.	Not Specified	
Strip Composition	12.8	0.10	18	
One Layer Cladding on A516-70	10.9 - 12.5	0.10	4 - 9	

⁽¹⁾Typical all weld metal. ⁽²⁾See test results disclaimer below.

NOTE: There are no AWS requirements for submerged arc stainless steel deposits. Deposit composition depends strongly upon dilution, especially on single layer welds.

Material Safety Data Sheets (MSDS) and Certificates of Conformance are available on our website at www.lincolnelectric.com

TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application.

CUSTOMER ASSISTANCE POLICY

The Lincoln Electric Company is manufacturing and selling high quality welding equipment, consumables, and cutting equipment. Our challenge is to meet the needs of our customers and to exceed their expectations. On occasion, purchasers may ask Lincoln Electric for information or advice about their use of our products. Our employees respond to inquiries to the best of their ability based on information provided to them by the customers and the knowledge they may have concerning the application. Our employees, however, are not in a position to verify the information provided or to evaluate the engineering requirements for the particular weldment. Accordingly, Lincoln Electric does not warrant or guarantee or assume any liability with respect to such information or advice. Moreover, the provision of such information or advice does not create, expand, or alter any warranty on our products. Any express or implied warranty that might arise from the information or advice, including any implied warranty of merchantability or any warranty of fitness for any customers' particular purpose is specifically disclaimed.

Lincoln Electric is a responsive manufacturer, but the selection and use of specific products sold by Lincoln Electric is solely within the control of, and remains the sole responsibility of the customer. Many variables beyond the control of Lincoln Electric affect the results obtained in applying these types of fabrication methods and service requirements.

Subject to Change – This information is accurate to the best of our knowledge at the time of printing. Please refer to www.lincolnelectric.com for any updated information.