LNM 307

TOP FEATURES

- The increased silicon content promotes weld pool fluidity resulting in a smoother weld deposit
- Useful in case of difficult weldability
- Often used as a buffer layer for hardfacing applications

TYPICAL APPLICATIONS

- Hardfacing
- Exhaust Systems
- Dissimilar joints
- Quenced and tempered steels

CLASSIFICATION

AWS A5.9	ER 18 8 Mn
EN ISO 14343-A	G 18 8 Mn

APPROVALS

TÜV, DB, CE

SHIELDING GASES (ACC. EN ISO 14175)

M12	Mixed gas Ar+ 0.5-5% CO_2
M13	Mixed gas Ar+ 0.5-3% O_2

CHEMICAL COMPOSITION (WEIGHT %), 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 (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J) +20°C
Typical values	M12	AW	400	630	40	80

AW = As welded

AVAILABLE SIZES AND PACKAGING INFORMATION

Wire diameter (mm)	Packaging	Weight (kg)	Item number
1.0	SPOOL (BS300)	15.0	581904
1.2	SPOOL (BS300)	15.0	581911
	DRUM	250.0	581914

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

Safety Data Sheets (SDS) are available here:

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