LNM 307

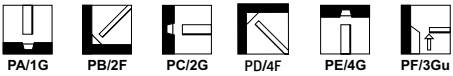
CLASSIFICATION

AWS A5.9	ER307*	**A-Nr**	8	**Mat-Nr**	1.4370
ISO 14343-A	G 18 8 Mn	**F-Nr**	6		
* Nearest classification		**9606 FM**	5		

GENERAL DESCRIPTION

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

WELDING POSITIONS (ISO/ASME)



SHIELDING GASES (ACC. ISO 14175)

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

APPROVALS

TÜV
+

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/mm²)	Tensile strength (N/mm²)	Elongation (%)	Impact ISO-V(J) +20°C
Typical values	M12	AW	400	630	40	80

EXAMPLES OF 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)	**0.8**	**1.0**	**1.2**
15 kg spool BS300	X	X	X
250 kg Accutrak® Drum			X

Other sizes and packaging on request

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