

LNM 310

CLASSIFICATION

AWS A5.9	ER310	A-Nr	9	Mat-Nr	1.4812
ISO 14343-A	G 25 20	F-Nr	6		
		9606 FM	5		

GENERAL DESCRIPTION

Solid wire for welding heat resistant Cr- and CrNi-steels [25%Cr-20%Ni]
High resistance to oxidation and scaling up to approx. 1100°C

WELDING POSITIONS (ISO/ASME)



PA/1G



PB/2F



PC/2G



PD/4F



PE/4G



PF/3Gu

SHIELDING GASES (ACC. ISO 14175)

M12	Mixed gas Ar+ 0.5-5% CO ₂
M13	Mixed gas Ar+ 0.5-3% O ₂

CHEMICAL COMPOSITION (W%) TYPICAL WIRE

C	Mn	Si	Cr	Ni	Mo
0.1	1.7	0.45	26	21	0.1

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	M12	AW	355	610	35	110

EXAMPLES OF MATERIALS TO BE WELDED

Steel grades	EN 10088-1/-2	EN 10213-4	Mat. Nr	ASTM/ACI	UNS
	X10CrAl24		1.4762		
		G-X25CrNiSi18-9	1.4825		
		G-X40CrNiSi22-9	1.4826		
	X15CrNiSi20-12		1.4828		
		G-X25CrNiSi20-14	1.4832		
	X15CrNiSi25-20		1.4841	310S CK20	S31008 J94202
	X12CrNi25-21		1.4845		
		G-X40CrNiSi 25-20	1.4848	HK40	

PACKAGING AND AVAILABLE SIZES

Diameter (mm)	1.0	1.2
15 kg spool BS300	X	X

Other sizes and packaging on request

LNM 310: rev. C-EN23-01/02/16