

P2000

CLASSIFICATION

Flux	Wire						
ISO 14174		ISO 14343-A	AWS A5.9/A5.9M			ISO 18274	AWS A5.14/ A5.14M
S A AF 2 64 DC H5	LNS 304L	S 19 9 L	ER308L	LNS NiCro 60/20		S Ni 6625	ERNiCrMo-3
	LNS 309L	S 24 12 L	ER309L	LNS NiCroMo 60/16		S Ni 6276	ERNiCrMo-4
	LNS 316L	S 19 12 3 L	ER316L	LNS NiCro 70/19		S Ni 6082	ERNiCr-3
	LNS 4462	S 22 9 3 N L	ER2209				
	LNS 318	S 19 12 3 Nb	ER318				
	LNS 347	S 19 9 Nb	ER347				
	LNS Zeron® 100X	S 25 9 4 N L	ER2594				
	LNS 4455	S 20 16 3 Mn L	ER316LMn				
	LNS 4500	S 20 25 5 Cu L	ER385				
	LNS 304H	S 19 9 H	ER308H				
LNS 307	S 18 8 Mn	ER307*					

GENERAL DESCRIPTION

Stainless steel welding flux
 Excellent slag release
 Low flux consumption
 Favorite choice with duplex and stabilized grades

APPROVALS

Wire grade	TÜV
LNS 304L	✓
LNS 316L	✓
LNS 318L	✓
LNS 347	✓
LNS 4455	✓

CHEMICAL COMPOSITION (W%), TYPICAL, ALL WELD METAL

Wire grade	C	Mn	Si	Cr	Ni	Mo	N	Nb	Cu	W	FN
LNS 304L	0.015	1.5	0.5	19	10						08-10
LNS 309L	0.015	1.5	0.5	23	13						10-20
LNS 316L	0.015	1.5	0.5	18	12	2.5					08-10
LNS 4462	0.015	1.5	0.5	22	8	3.0	0.1				40-60
LNS 318	0.04	1.5	0.5	19	11	2.5		0.5			08-10
LNS 347	0.03	1.4	0.5	19	10			0.6			08-10
LNS Zeron® 100X	0.03	0.6	0.5	25	9.5	3.6	0.2		0.7	0.6	30-60
LNS NiCro 60/20	0.006	0.1	0.4	21.5	64.5	8.7		3.8			
LNS 4455	0.025	6	0.5	18.5	15	2.6	0.15				
LNS 4500	0.03	1.5	0.6	19	25	4.1			1.2		

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

Wire grade	Condition*	Yield strength (N/mm ²)	Tensile strength (N/mm ²)	Elongation (%)	Impact ISO-V(J)			
					+20°C	-20°C	-40°C	-196°C
LNS 304L	AW	380	550	35		80		
LNS 309L	AW	425	580	33			80	
LNS 316L	AW	425	560	33				50
LNS 4462	AW	550	800	27				50
LNS Zeron® 100X	AW	670	880	21		70	45	
LNS NiCro 60/20	AW	520	780	40				100
LNS 347	AW	470	620	30	90			35
LNS 4455	AW	360	640	30				
LNS 310	AW	440	600	28				

AW : As welded

P2000: rev. C-EN26-10/09/19

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 updated information.

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EXAMPLES OF MATERIALS TO BE WELDED

AISI	Mat.nr.	EN 10088-1/2	ASTM/ACI	UNS	Wire
304L	1.4306	X2CrNi19-11	(TP) 304L	S30403	LNS 304L
304LN	1.4311	X2CrNiN18-10	(TP) 304LN	S30453	LNS 304L
316LN	1.4406	X2CrNiMoN17-11-2	(TP) 316LN	S31653	LNS 316L
316L	1.4404	X2CrNiMo17-12-2	(TP) 316L	S31603	LNS 316L
316L	1.4435	X2CrNiMo18-14-3	(TP) 316L	S31603	LNS 316L
316LN	1.4429	X2CrNiMoN17-13-3			LNS 316L
304	1.4301	X4CrNi18-10	(TP) 304	S30409	LNS 304L
321	1.4541	X6CrNiTi18-10	(TP) 321	S32100	LNS 304L/347
316	1.4401	X4CrNiMo17-12-2	(TP) 316	S31600	LNS 316L
316	1.4436	X4CrNiMo17-13-3			LNS 316L
347	1.4550	X6CrNiNb18-10	(TP) 347	S34700	LNS 304L/347
318	1.4580	X6CrNiMoNb17-12-2	316Cb	S31640	LNS 316L/318
318	1.4583	X10CrNiMoNb18-12(DIN)			LNS 316L/318
317LN	1.4439	X2CrNiMoN17-13-5	316LN	S31726	4439Mn
	1.4539	X1NCrNiMoCu25-20-5			4500
	1.3952	X2CrNiMoN18-14-3(DIN)			4455
	1.4462	X2CrNiMoN22-5-3			4462
			Zeron® 100	S32760	LNS Zeron® 100 X
	2.4856	NiCr22Mo9Nb(DIN)		N06625	LNS NiCro 60/20
	1.5637	12Ni14 (DIN)			LNS NiCro 60/20
	1.5680	12Ni19 (DIN)			LNS NiCro 60/20
	1.5662	X8Ni9 (DIN)			LNS NiCro 60/20

FLUX CHARACTERISTICS

Current type	DC
Basicity (Boniszewski)	1.6
Solidification speed	High
Density (kg/dm³)	1.2
Grain size (ISO 14174)	2 -20

SUGGESTIONS FOR USE

General stainless steel welding flux
 Applicable in the boiler and pressure vessel industry as well as pipe fabrication
 Due to low Si-content very good impact toughness at low temperature

PACKAGING AND AVAILABLE SIZES

Unit	Net weight (kg)
Sahara ReadyBag™ (SRB)	25