

LNT 304LSi

CLASSIFICATION

AWS A5.9 - ER308LSi
ISO 14343-A - W 19 9 L Si

GENERAL DESCRIPTION

**Solid rod with extra low carbon for welding austenitic CrNi-steels
With increased silicon for improved wettability**

SHIELDING GASES (ACC. ISO 14175)

I1 Inert gas Ar (100%)

APPROVALS

DNV	TÜV	CE	DB
+	+	+	+

CHEMICAL COMPOSITION (W%) TYPICAL WIRE

C	Mn	Si	Cr	Ni	Mo
0.02	2.0	0.8	20	10	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	-196°C
Typical values	I1	AW	467	622	37	147	67

MATERIALS TO BE WELDED

Steel grades	EN 10088-1/-2	EN 10213-4	Mat. Nr	ASTM/ACI A240/A312/A351	UNS
Extra low carbon (C < 0.03%)	X2CrNi19 11		1.4306	(TP)304 L CF-3	S30403 J92500
	X2CrNiN18 10		1.4311	(TP)304LN 302, 304	S30453 S30400
Medium carbon (C > 0.03%)	X4CrNi18 10		1.4301 1.4308	(TP)304 CF-8	S30409 J92600
		GX5CrNi19 10			
Ti-,Nb stabilized	X6CrNiTi18 10		1.4541	(TP)321 (TP)321H	S32100 S32109
	X6 CrNiNb 18 10		1.4550	(TP)347	S34700
		GX5 CrNiNb 19 10	1.4552	CF-8C	J92710

PACKAGING AND AVAILABLE SIZES

Diameter (mm)	1.0	1.2	1.6	2.0	2.4	3.2	
Unit : 2 / 5 / 10 kg tube	X	X	X	X	X	X	Note : Cut length = 1000 mm

Other sizes and packaging on request

LNT 304LSi: rev. EN 22