

LNM 310

MIG (GMAW)

SOLID WIRE

PRODUCT 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

CLASSIFICATIONS

AWS A5.9 ER310
ISO 14343-A G 25 20

ASME IX QUALIFICATION

QW432 F-No 6
QW442 A-No 9
Mat-Nr 1.4812

SHIELDING GASES (ACC. ISO 14175)

M12 Mixed gas Ar+ 0.5-5% CO₂
M13 Mixed gas Ar+ 0.5-3% O₂

CHEMICAL COMPOSITION (WELD METAL WT %)

	C	Mn	Si	Cr	Ni	Mo
Min.	0.08	1.0	--	24.0	18.0	--
Max.	0.15	2.5	2.0	27.0	22.0	0.3
Typical	0.1	1.7	0.45	26	21	0.1

ALL-WELD MECHANICAL PROPERTIES

As welded	Typical
Tensile strength (MPa)	610
0.2% proof strength (MPa)	355
Elongation (%)	35
Impact ISO-V(J) +20°C	110

PACKAGING DATA

Diameter (mm)	Weight (kg)	Packaging	Item number
1.0	15	BS300	581935
1.2	15	BS300	595871