

# LNM 318Si

## CLASSIFICATION

<b>AWS A5.9</b>	ER318*	<b>A-Nr</b>	8	<b>Mat-Nr</b>	1.4576
<b>ISO 14343-A</b>	G 19 12 3 NbSi	<b>F-Nr</b>	6		
* Nearest classification		<b>9606 FM</b>	5		

## GENERAL DESCRIPTION

Solid wire for welding Ti or Nb stabilized stainless CrNiMo-steels  
High resistance to intergranular corrosion and general corrosion conditions

## WELDING POSITIONS (ISO/ASME)



## APPROVALS

TÜV

+

## SHIELDING GASES (ACC. ISO 14175)

<b>M12</b>	Mixed gas Ar+ 0.5-5% CO <sub>2</sub>
<b>M13</b>	Mixed gas Ar+ 0.5-3% O <sub>2</sub>

## CHEMICAL COMPOSITION (W%) TYPICAL WIRE

C	Mn	Si	Cr	Ni	Mo	Nb
0.04	1.4	0.85	18.9	11.7	2.7	0.5

## MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Shielding gas	Condition	0.2% proof strength [N/mm <sup>2</sup> ]	Tensile strength [N/mm <sup>2</sup> ]	Elongation [%]	Impact ISO-V(J) +20°C
Typical values	M12	AW	410	630	35	100

## EXAMPLES OF MATERIALS TO BE WELDED

Steel grades	EN 10088-1/-2	EN 10213-4	Mat. Nr	ASTM/ACI A240/A312/A351	UNS
<b>Extra low carbon [C &lt; 0.03%]</b>					
	X2CrNiMo17-12-2		1.4404	(TP)316L CF-3M	S31603 J92800
	X2CrNiMo18-14-3		1.4435	(TP)316L	S31603
	X2CrNiMoN17-11-2		1.4406	(TP)316LN	S31653
	X2CrNiMoN17-13-3		1.4429		
<b>Medium carbon [C &gt; 0.03%]</b>					
	X4CrNiMo17-12-2		1.4401	(TP)316	S31600
	X4CrNiMo17-13-3		1.4436		
		G-X5CrNiMo19-11	1.4408	CF 8M	J92900
<b>Ti-,Nb stabilized</b>					
	X6CrNiMoTi17-12-2		1.4571	316Ti	S31635
	X6CrNiMoNb17-12-2		1.4580	316Cb	S31640
	X6CrNiNb18-10		1.4550	(TP)347	S34700
		G-X5CrNiNb 19-10	1.4552	CF-8C	J92710

## PACKAGING AND AVAILABLE SIZES

Diameter [mm]	1.0	1.2
<b>15 kg spool BS300</b>	X	X
Other sizes and packaging on request		

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