

LNM 304LSi

CLASSIFICATION

AWS A5.9	ER308LSi	A-Nr	8	Mat-Nr	1.4316
ISO 14343-A	G 19 9 L Si	F-Nr	6		
		9606 FM	5		

GENERAL DESCRIPTION

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

WELDING POSITIONS (ISO/ASME)



PA/1G

PB/2F

PC/2G

PD/4F

PE/4G

PF/3Gu

SHIELDING GASES (ACC. ISO 14175)

M11	Mixed gas Ar+ 0.5-5% CO ₂ + 0.5-5% H ₂
M12	Mixed gas Ar+ 0.5-5% CO ₂
M13	Mixed gas Ar+ 0.5-3% O ₂

APPROVALS

ABS	BV	DNV	GL	LR	TÜV
+	+	+	+	+	+

CHEMICAL COMPOSITION (W%) TYPICAL WIRE

C	Mn	Si	Cr	Ni	Mo
0.02	1.9	0.8	20	10	0.1

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

Typical values	Shielding gas	Condition	0.2% proof strength	Tensile strength	Elongation	Impact ISO-V(J)	
			[N/mm ²]	[N/mm ²]	(%)	-20°C	-196°C
	M12	AW	394	568	40	85	41

EXAMPLES OF MATERIALS TO BE WELDED

Steel grades	EN 10088-1/2	EN 10213-4	Mat. Nr	ASTM/AISI 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
	X6CrNiNb18-10		1.4550 1.4552	(TP)347 CF-8C	S34700 J92710
		GX5 CrNiNb 19 10			

PACKAGING AND AVAILABLE SIZES

Diameter (mm)	0.8	1.0	1.2
5 kg plastic spool S200	X	X	X
15 kg spool BS300	X	X	X
250 kg Accutrak® Drum			X

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Other sizes and packaging on request

LINCOLN
ELECTRIC

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