

LNM 307

CLASSIFICATION

AWS A5.9	ER307*	A-Nr	8	Mat-Nr	1.4370
ISO 14343-A	G 18 8 Mn	F-Nr	6		
* Nearest classification		9606 FM	5		

GENERAL DESCRIPTION

Solid wire for welding austenitic and ferritic stainless steels with difficult weldability
Often used as a buffer layer for hardfacing applications

WELDING POSITIONS (ISO/ASME)



PA/1G



PB/2F



PC/2G



PD/4F



PE/4G



PF/3Gu

SHIELDING GASES (ACC. ISO 14175)

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

APPROVALS

TÜV

+

CHEMICAL COMPOSITION (W%) TYPICAL WIRE

C	Mn	Si	Cr	Ni
0.07	71	0.8	18.6	8.0

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
Typical values	M12	AW	400	630	40	80

EXAMPLES OF MATERIALS TO BE WELDED

Various steel grades, such as:

- Armour plate
- Hardenable steels including steels difficult to weld
- Non-magnetic steels
- Work hardening austenitic manganese steels
- Dissimilar joints (CMn-steels to stainless steels)
- Exhaust systems

PACKAGING AND AVAILABLE SIZES

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

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Other sizes and packaging on request