

# LNM 318Si

## CLASSIFICATION

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



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 <sub>2</sub>
M13	Mixed gas Ar+ 0.5-3% O <sub>2</sub>

## APPROVALS

TÜV

+

## CHEMICAL COMPOSITION (W%) TYPICAL WIRE

C	Mn	Si	Cr	Ni	Mo	Nb
0.05	1.4	0.7	18.6	11.7	2.5	0.7

## 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
Extra low carbon [C < 0.03%]					
	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		
Medium carbon [C > 0.03%]					
	X4CrNiMo17-12-2		1.4401	(TP)316	S31600
	X4CrNiMo17-13-3		1.4436		
		G-X5CrNiMo19-11	1.4408	CF 8M	J92900
Ti-,Nb stabilized					
	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
15 kg spool BS300	X	X

Other sizes and packaging on request

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