

P2000

CLASSIFICATION

Flux	wire				
ISO 14174	ISO 14343-A	AWS A5.9/A5.9M	ISO 18274	AWS A5.14/ A5.14M	
S A AF 2 64 DC H5	LNS 304L	S 19 9 L	ER308L	LNS NiCro 60/20	S Ni 6625 ERNiCrMo-3
	LNS 309L	S 24 12 L	ER309L	LNS NiCroMo 60/16	S Ni 6276 ERNiCrMo-4
	LNS 316L	S 19 12 3 L	ER316L	LNS NiCro 70/19	S Ni 6082 ERNiCr-3
	LNS 4462	S 22 9 3 N L	ER2209		
	LNS 318	S 19 12 3 Nb	ER318		
	LNS 347	S 19 9 Nb	ER347		
	LNS Zeron 100X	S 25 9 4 N L	ER2594		
	LNS 4455	S 20 16 3 Mn L	ER316LMn		
	LNS 4500	S 20 25 5 Cu L	ER385		
	LNS 304H	S 19 9 H	ER308H		
	LNS 307	S 18 8 Mn	ER307*		

GENERAL DESCRIPTION

Stainless steel welding flux
 Excellent slag release
 Low flux consumption
 Favorite choice with duplex and stabilized grades

APPROVALS

Wire grade	TÜV
LNS 304L	✓
LNS 316L	✓
LNS 318L	✓
LNS 347	✓
LNS 4455	✓

CHEMICAL COMPOSITION (W%), TYPICAL, ALL WELD METAL

Wire grade	C	Mn	Si	Cr	Ni	Mo	N	Nb	Cu	W	FN
LNS 304L	0.015	1.5	0.5	19	10						08-10
LNS 309L	0.015	1.5	0.5	23	13						10-20
LNS 316L	0.015	1.5	0.5	18	12	2.5					08-10
LNS 4462	0.015	1.5	0.5	22	8	3.0	0.1				40-60
LNS 318	0.04	1.5	0.5	19	11	2.5		0.5			08-10
LNS 347	0.03	1.4	0.5	19	10			0.6			08-10
LNS Zeron 100X	0.03	0.6	0.5	25	9.5	3.6		0.2	0.7	0.6	30-60
LNS NiCro 60/20	0.006	0.1	0.4	21.5	64.5	8.7	3.8			0.8	
LNS 4455	0.025	6	0.5	18.5	15	2.6	0.15				
LNS 4500	0.03	1.5	0.6	19	25	4.1			1.2		

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

Wire grade	Condition*	Yield strength (N/mm ²)	Tensile strength (N/mm ²)	Elongation (%)	Impact ISO-V(J)			
					+20°C	-40°C	-196°C	-20°C
LNS 304L	AW	380	550	35				80
LNS 309L	AW	425	580	33		80		
LNS 316L	AW	425	560	33			50	
LNS 4462	AW	550	800	27		50		
LNS Zeron 100X	AW	670	880	21		45		70
LNS NiCro 60/20	AW	520	780	40			100	
LNS 347	AW	470	620	30	90		35	
LNS 4455	AW	360	640	30				
LNS 310	AW	440	600	28				

P2000: rev. EN 24

AW : As welded

All information in this data sheet is accurate to the best of our knowledge at the time of printing. Please refer to www.lincolnelectric.eu for any updated information. Fumes: Material Safety Data Sheets (MSDS) are available on our website.

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MATERIALS TO BE WELDED

AISI	Mat.nr.	EN 10088-1/2	ASTM/ACI	UNS	Wire
304L	1.4306	X2 CrNi 19-11	(TP) 304L	S30403	LNS 304L
304LN	1.4311	X2 CrNiN 18-10	(TP) 304LN	S30453	LNS 304L
316LN	1.4406	X2 CrNiMoN 17-11-2	(TP) 316LN	S31653	LNS 316L
316L	1.4404	X2 CrNiMo 17-12-2	(TP) 316L	S31603	LNS 316L
316L	1.4435	X2 CrNiMo 18-14-3	(TP) 316L	S31603	LNS 316L
316LN	1.4429	X2 CrNiMoN 17-13-3			LNS 316L
304	1.4301	X4 CrNi 18-10	(TP) 304	S30409	LNS 304L
321	1.4541	X6 CrNiTi 18-10	(TP) 321	S32100	LNS 304L/347
316	1.4401	X4 CrNiMo 17-12-2	(TP) 316	S31600	LNS 316L
316	1.4436	X4 CrNiMo 17-13-3			LNS 316L
347	1.4550	X6 CrNiNb 18-10	(TP) 347	S34700	LNS 304L/347
318	1.4580	X6 CrNiMoNb 17-12-2	316Cb	S31640	LNS 316L/318
318	1.4583	X10 CrNiMoNb 18-12(DIN)			LNS 316L/318
317LN	1.4439	X2 CrNiMoN 17-13-5	316LN	S31726	4439Mn
	1.4539	X1 NCrMoCu 25-20-5			4500
	1.3952	X2 CrNiMoN 18-14-3(DIN)			4455
	1.4462	X2 CrNiMoN 22-5-3			4462
	2.4856	NiCr22Mo9Nb(DIN)	Zeron 100	S32760	LNS Zeron 100 X
	1.5637	12Ni14 (DIN)		N06625	LNS NiCro 60/20
	1.5680	12Ni19 (DIN)			LNS NiCro 60/20
	1.5662	X8Ni9 (DIN)			LNS NiCro 60/20

FLUX CHARACTERISTICS

Current type	DC
Basicity (Boniszewski)	1.6
Solidification speed	High
Density (kg/dm ³)	1.2
Grain size (ISO 14174)	2 -20

SUGGESTIONS FOR USE

- General stainless steel welding flux
- Applicable in the boiler and pressure vessel industry as well as pipe fabrication
- Due to low Si-content very good impact toughness at low temperature

PACKAGING AND AVAILABLE SIZES

Unit	Net weight (kg)
Sahara ReadyBag™ (SRB)	25