

**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 AC 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
- Homogeneous stainless steel colour bead appearance
- Straight edges on butt welds applications
- Excellent behaviour on 9% Nickel steel
- Suitable in AC current

**APPROVALS**

Wire grade	ABS	LRS	TÜV
LNS 304L	✓	✓	
LNS 309L	✓	✓	
LNS 316L	✓	✓	
LNS 4462	5YQ550	S31803	✓

**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		

AW : As welded

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## MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

Wire grade	Condition*	Yield strength (N/mm <sup>2</sup> )	Tensile strength (N/mm <sup>2</sup> )	Elongation (%)	Impact ISO-V(J)			
					-20°C	-40°C	-50°C	-196°C
LNS 304L	AW	390	550	35	80	75		40
LNS 309L	AW	400	580	33		70		
LNS 316L	AW	400	560	33	75	70		45
LNS 347	AW	400	650	34			65	
LNS 4462	AW	585	765	27		75		
LNS Zeron 100X	AW	670	880	21	70	45		
LNS NiCro 60/20	AW	520	780	40				100
LNS 4439Mn		375	630	33				

## 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	318Cb	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 NCrNiMoCu 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 <sup>3</sup> )	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
Drum	40