

# 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)

M12	Mixed gas Ar+ 0.5-5% CO <sub>2</sub>
M13	Mixed gas Ar+ 0.5-3% O <sub>2</sub>

## 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 <sup>2</sup> )	(N/mm <sup>2</sup> )	(%)	-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/ACI A240/A312/A351	UNS
<b>Extra low carbon [C &lt; 0.03%]</b>					
	X2CrNi19-11		1.4306	(TP)304 L CF-3	S30403 J92500
	X2CrNiN18-10		1.4311	(TP)304LN 302, 304	S30453 S30400
<b>Medium carbon [C &gt; 0.03%]</b>					
	X4CrNi18-10		1.4301	(TP)304	S30409
		GX5CrNi19 10	1.4308	CF-8	J92600
<b>Ti-,Nb stabilized</b>					
	X6CrNiTi18-10		1.4541	(TP)321 (TP)321H	S32100 S32109
	X6CrNiNb18-10		1.4550	(TP)347	S34700
		GX5 CrNiNb 19 10	1.4552	CF-8C	J92710

## 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

LNM 304LSi: rev. C-EN24-01/02/16

Other sizes and packaging on request

**LINCOLN**  
**ELECTRIC**  
THE WELDING EXPERTS®

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