

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	7.1	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

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: Safety Data Sheets (SDS) are available on our website.