

LNM 307

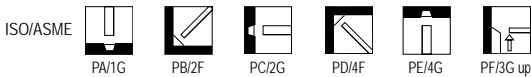
CLASSIFICATION

AWS A5.9 - ER307* * Nearest classification
ISO 14343-A - G 18 8 Mn

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



SHIELDING GASES (ACC. ISO 14175)

M12 Mixed gas Ar+ 0.5-5% CO₂
M13 Mixed gas Ar+ 0.5-3% O₂

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

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	1.6
15 kg spool BS300	X	X	X	X
Unit : 250 kg Accutrak drum			X	
Other sizes and packaging on request				

LNM 307 rev. EN 22

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.