

## Flux

### Classification

Flux P2000S :	EN 760 :	S A AF 2 64Cr DC H5
Wire	ISO 14343-A	
LNS 309L	S 24 12 L	
LNS 4462	S 22 9 3 N L	
LNS Zeron 100X	S 25 9 4 N L	

### General description

Compensates Cr-burn off and increases the Cr-content in the weldmetal

Welding stainless steel to carbon steel

To be used to weld first layers in carbon steel with over-alloyed wires

Applicable where a higher weldmetal ferrite is needed

### Chemical composition (w%), typical, all weld metal

Wire grade	C	Mn	Si	Cr	Ni	Mo	N	other	FN
LNS 309L	0.015	1.5	0.5	25	13				15-20
LNS 4462	0.015	1.5	0.5	24	8	3	0.1		40-60
LNS Zeron 100X	0.02	0.5	0.4	26	9	3.7	0.2	W=0.6 Cu = 0.7	30-60

### Mechanical properties, typical, all weld metal

Wire grade	Yield strength (N/mm <sup>2</sup> )	Tensile strength (N/mm <sup>2</sup> )	Elongation (%)	Impact ISO-V(J) -40°C
LNS 309L	450	600	33	80
LNS 4462	700	850	27	50
LNS Zeron 100X	670	880	25	45

P2000S: rev. EN 22

**Liability:** All information in this data sheet is based on the best available knowledge, is subject to change without notice and can only be considered as suitable for general guidance **Fumes:** Consult information on Welding Safety Sheet, available upon request

## Suggestions for use

Especially developed for welding stainless steel to carbon steel. Also to be used in welding root runs in clad steel as well as root runs in Nitrogen alloyed fully austenitic steels to avoid hot cracking

## Materials to be welded

Dissimilar  
Duplex

## Flux characteristics

Current type	DC (+,-)
Basicity (Boniszewski)	1,6
Solidification speed	high
Density (kg/dm <sup>3</sup> )	1,2
Grain size	1-16

## Packaging and available sizes

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