

Flux

Classification

Flux P2007	EN 760 :	S A AF 2 64 AC H5			
Wire	ISO 14343-A	AWS A5.9/A5.9M	Wire	ISO 18274	AWS A5.14/A5.14M
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 NiCroMo 59/23	S Ni 6059	ERNiCrMo-13
LNS 4462	S 22 9 3 N L	ER2209	LNS NiCro 70/19	S Ni 6082	ERNiCr-3
LNS 318	S 19 12 3 Nb	ER318			
LNS 347	S 19 9 Nb	ER347			
LNS Zeron 100X	S 25 9 4 N L	ER2553*			
LNS 4439Mn	S 18 16 5 N L	-			
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 310	S 25 20	ER310			
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	DNV	TUV
LNS 304L	x	x	x	
LNS 309L	x	x	x	
LNS 316L	x	x	x	
LNS 4462				x

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	0.1				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 4439Mn	0.025	3.6	0.5	18	17	3.6	0.15				
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		

P2007: rev. EN 03

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

Mechanical properties, typical, all weld metal

Wire grade	Condition	Yield strength (N/mm ²)	Tensile strength (N/mm ²)	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 NiCro 60/20	AW	520	780	40				100
LNS Zeron 100X	AW	670	880	21	70	45		
LNS 4439Mn	AW	375	630	33				

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

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	316Cb	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 NCrMoCu 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 (+,-) / AC
Basicity (Boniszewski)	1,6
Solidification speed	High
Density (kg/dm ³)	1,2
Grain size	2-20

Packaging and available sizes

Unit	Net weight (kg)
Sahara ReadyBag™ (SRB)	25
Drum	40