

## CLASSIFICATION

EN 1600 : E 25 20 R 12      Werkstoff-Nr : 1.4842  
AWS A5.4 : E310-16

## GENERAL DESCRIPTION

LSN-310 is a rutile coated fully austenitic electrode. It gives a fully austenitic filler metal of the Cr-Ni type. Weld beads are highly resistant to oxidation at operating temperatures up to 1150°C.

## APPROVALS

GOST, SEPRO, TSE

## APPLICATIONS AND MATERIALS TO BE WELDED

It is an ideal electrode for welding heat resistant stainless steels of the AISI 309 and AISI 310 type. It is used for welding unalloyed steels to stainless steels and to air hardening steels like armour plates. LSN-310 can be used in the welding of chimneys, boilers and heating plates and also for industrial furnaces operating at high temperatures (that are frequently made from ferritic steels of Cr-Si-Al type).

During the welding of high carbon steels to stainless steels, it gives a weld bead that has a better machinability as compared to beads of electrodes with 18 % Cr and 8 % Ni.

## CHEMICAL COMPOSITION (W%), TYPICAL, ALL WELD METAL

C	Si	Mn	Cr	Ni
0.10	0.60	1.70	26.00	21.00

## MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

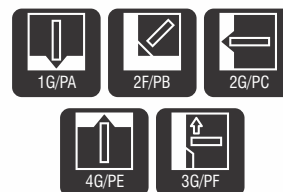
Yield Strength	: 480 N/mm <sup>2</sup>
Tensile Strength	: 600 N/mm <sup>2</sup>
Elongation (L=5d)	: 35 %
Impact (ISO-V)	: 60 J (+20°C)

	EN 10088-1/-2	EN 10213-4	W. Nr
<b>Heat Resistant Cr and Cr-Ni Steels</b>	X10 CrAl 7	-	1.4713
	X10 CrAl 24	-	1.4762
	-	G-X40 CrSi 17	1.4740
	-	G-X25 CrNiSi 18 9	1.4825
	-	G-X40 CrNiSi 22 9	1.4826
	X15 CrNiSi 20 12	-	1.4828
	-	G-X25 CrNiSi 20 14	1.4832
	X15 CrNiSi 25 20	-	1.4841
	X12 CrNi 25 21	-	1.4845
	-	G-X40 CrNiSi 25 20	1.4848

## WELDING PARAMETERS / PACKING AND DIAMETER INFORMATIONS / WELDING POSITIONS

Current Type and Polarity : AC min 70 V ; DC (+)

Diameter [ mm ]	Length [ mm ]	Current [ A ]	Electrode Weight [ g/100 pcs ]	Box Weight [ kg ] Quantity [ pcs/box ]	Export Box Box Weight [ kg ]
2.00	250	45 - 60	1036	1.7 / 155	1.5
2.50	250	60 - 80	1650	1.6 / 100	1.5
3.25	300	80 - 120	3280	2.0 / 60	2.0
4.00	350	100 - 140	5740	2.3 / 40	2.5
5.00	350	130 - 160	8810	2.2 / 25	2.5



**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.

### Lion International U.K (M.E.) Limited

Monomark House, 27 Old Gloucester Street, London WC1N 3XX, United Kingdom.  
T: +44 20 74198760 F: +44 20 78319489 E: info@lionintweld.co.uk

### Lion International Middle East FZC

P.O. Box 41654, W/H No. 1K-01/4, Hamriyah Free Zone, Sharjah, UAE.  
T: +971 6 5260461 F: +971 6 5260561 E: info.me@lionintweld.co.uk