

CLASSIFICATION

EN 1600 : E 19 12 3 R 73 Werkstoff-Nr : 1.4430
AWS A5.4 : (E316-16)

GENERAL DESCRIPTION

LSN-316S is a rutile coated electrode with an unalloyed core. Therefore it can tolerate higher currents than LSN-316 L. It has 160 % metal recovery. It gives a filler metal of the Cr-Ni-Mo type. Excellent quality smooth weld beads are highly resistant to acids and to intergranular corrosion at operating temperatures up to 350°C. It gives a stable arc and the slag is easy to remove.

APPROVALS

GOST, SEPRO

APPLICATIONS AND MATERIALS TO BE WELDED

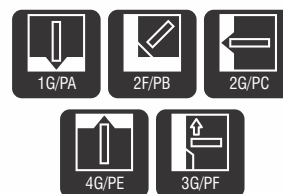
It is an ideal electrode for the welding of austenitic steels and acid resistant steels of the AISI 316 type. It is used for welding mild and low alloyed steels to stainless steels or austenitic manganese steels. It can also be used for stainless cladding of carbon and manganese steels. LSN-316S can be used in the welding of pipes, tanks and vessels that are used in chemical, paint and paper industries. Cr-Ni-Mo steels, steel cast parts and pipes that are used for acid, gas and vapor transmission can also be welded with this electrode. LSN-316S can also be used in the build up welding of leakproof surfaces. Electrode diameters up to 3.25 mm can be used in all positions; whereas 4 and 5 mm electrodes should be used in flat and nearly flat position only.

| | EN 10088-1/-2 | EN 10213-4 | W. Nr |
|---|--------------------|-------------------|--------|
| Extra Low Carbon Stainless Steels (C < %0.03) | X2 CrNiMo 17 12 2 | – | 1.4404 |
| | X2 CrNiMo 18 14 3 | – | 1.4435 |
| | X2 CrNiMoN 17 11 2 | – | 1.4406 |
| | X2 CrNiMoN 17 13 3 | – | 1.4429 |
| Medium Carbon Stainless Steels (C > %0.03) | X4 CrNiMo 17 12 2 | – | 1.4401 |
| | X4 CrNiMo 17 13 3 | – | 1.4436 |
| | – | G-X5 CrNiMo 19 11 | 1.4408 |

WELDING PARAMETERS / PACKING AND DIAMETER INFORMATIONS / WELDING POSITIONS

Current Type and Polarity : AC min 50 V ; DC (+)

| Diameter [mm] | Length [mm] | Current [A] | Electrode Weight [g/100 pcs] | Box Weight [kg] Quantity [pcs/box] | Export Box Box Weight [kg] |
|-----------------|---------------|---------------|--------------------------------|--|------------------------------|
| 2.50 | 350 | 80 - 120 | 3190 | 1.9 / 60 | 2.5 |
| 3.25 | 350 | 100 - 140 | 5520 | 1.9 / 35 | 2.5 |
| 4.00 | 350 | 110 - 180 | 8500 | 2.1 / 25 | 2.5 |
| 5.00 | 350 | 200 - 240 | 12500 | 1.9 / 15 | 2.5 |



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

| C | Si | Mn | Cr | Ni | Mo |
|------|------|------|-------|-------|------|
| 0.06 | 0.70 | 0.60 | 17.00 | 11.00 | 2.90 |

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

| | |
|-------------------|-------------------------|
| Yield Strength | : 440 N/mm ² |
| Tensile Strength | : 565 N/mm ² |
| Elongation (L=5d) | : 30 % |
| Impact (ISO-V) | : 70 J (+20°C) |

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.

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