

## Flux

### Classification

Flux P2000	EN 760 : A AF2 63 AC H5
Flux / wire	EN 12072
P2000 / LNS 304L	S 19 9 L
P2000 / LNS 309L	S 24 12 L
P2000 / LNS 316L	S 19 12 3 L
P2000 / LNS 4462	S 22 9 3 N L
P2000 / LNS 318	S 19 12 3 Nb
P2000 / LNS 347	S 19 9 Nb
P2000 / LNS Zeron 100X	S 25 9 4 N L

### General description

**Perfect stainless steel welding flux**  
**Excellent slag release, also in narrow gaps**  
**Low flux consumption**  
**Extra moisture resistant and low hydrogen content**  
**No residual slag on the welded seam**  
**Suitable for 3.5, 5 and 9% nickel steel**

### Approvals

Wire grade	LR	BV	ABS	DNV	GL	Controlas	TUV	DB	UDT
LNS304L					x	x	x		x
LNS309L				x					x
LNS316L	x		x	x			x		x
LNS4462	x			x	x	x	x		x
LNS318							x		x
LNS347							x		x

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

Wire grade	C	Mn	Si	Cr	Ni	Mo	N	Nb	FN
LNS304L	0.015	1.5	0.5	19	10				8-10
LNS309L	0.015	1.5	0.5	23	13				10-20
LNS316L	0.015	1.5	0.5	18	12	2.5			8-10
LNS4462	0.015	1.5	0.5	22	8	3	0.1		40-60
LNS318	0.04	1.5	0.5	19	11	2.5		0.5	8-10
LNS347	0.03	1.4	0.5	19	10			0.6	8-10

### Mechanical properties, all weld metal

Wire grade	Yield strength	Tensile strength	Elongation	Impact ISO-V(J)		
	(N/mm <sup>2</sup> )	(N/mm <sup>2</sup> )	%	-20°C	-40°C	-196 °C
LNS304L	380	550	35	80		
LNS309L	425	580	33		80	
LNS316L	425	560	33			50
LNS4462	550	800	27		50	

## Suggestions for use

General stainless steel welding flux

Very good applicable in the boiler and pressure vessel industry as well as pipe fabrication

Due to relative 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 LNS
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)	Zeron 100	S32760	LNS 316L/318 LNS Zeron 100 X

## Flux characteristics

Max current, one wire (A)	700
Current type	DC (+,-)
Basicity (Boniszewski)	1.6
Solidification speed	high
Density (kg/dm <sup>3</sup> )	1.2
Grain	2-20

## Packaging

Unit	Net weight (kg)
Bag	25