

# LNT 310

## CLASSIFICATION

AWS A5.9 - ER310  
ISO 14343-A - W 25 20

## GENERAL DESCRIPTION

**Solid rod for welding heat resistant Cr- and CrNi-steels (25%Cr-20%Ni)**  
**High resistance to oxidation and scaling up to approx. 1100°C**

## SHIELDING GASES (ACC. ISO 14175)

I1 Inert gas Ar (100%)

## CHEMICAL COMPOSITION (W%) TYPICAL WIRE

C	Mn	Si	Cr	Ni	Mo
0.1	1.7	0.5	26	21	0.1

## MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Shielding gas	Condition	0.2% proof strength (N/mm <sup>2</sup> )	Tensile strength (N/mm <sup>2</sup> )	Elongation (%)	Impact ISO-V(J) +20°C
Typical values	I1	AW	360	600	35	100

## MATERIALS TO BE WELDED

Steel grades	EN 10088-1/-2	EN 10213-4	Mat. Nr	ASTM/ACI	UNS
	X10 CrAl24		1.4762		
		GX25 CrNiSi18-9	1.4825		
		GX40 CrNiSi22-9	1.4826		
	X15 CrNiSi20-12		1.4828		
		GX25 CrNiSi20-14	1.4832		
	X15 CrNiSi25-20		1.4841	310S	S31008
				CK20	J94202
	X12 CrNi25-21		1.4845		
		GX40 CrNiSi 25-20	1.4848	HK40	

## PACKAGING AND AVAILABLE SIZES

Diameter (mm)	1.6	2.0	2.4	3.2
Unit : 2 & 10 kg tube	X	X	X	X

Other sizes and packaging on request

LNT 310 rev. EN 22