

P2000S

CLASSIFICATION

Flux	wire	
ISO 14174	ISO 14343-A	
S A AF 2 64Cr DC H5	LNS 309L	S 24 12 L
	LNS 4462	S 22 9 3 N L
	LNS Zeron 100X	S 25 9 4 N L

GENERAL DESCRIPTION

Compensates Cr-burn off and increases the Cr-content in the weldmetal

Welding stainless steel to carbon steel

To be used to weld first layers in carbon steel with over-alloyed wires

Applicable where a higher weldmetal ferrite is needed

APPROVALS

Wire grade	TÜV
LNS 309L	✓
LNS 4462	✓

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

Wire grade	C	Mn	Si	Cr	Ni	Mo	N	Cu	W	FN
LNS 309L	0.015	1.5	0.5	25	13					15-20
LNS 4462	0.015	1.5	0.5	24	8	3.0	0.1			40-60
LNS Zeron 100X	0.02	0.5	0.4	26	9	3.7	0.2	0.7	0.6	30-60

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

Wire grade	Yield strength (N/mm ²)	Tensile strength (N/mm ²)	Elongation (%)	Impact ISO-V(J)
				-40°C
LNS 309L	450	600	33	80
LNS 4462	700	850	27	50
LNS Zeron 100X	670	880	25	45

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MATERIALS TO BE WELDED

Dissimilar
Duplex

SUGGESTIONS FOR USE

Especially developed for welding stainless steel to carbon steel. Also to be used in welding root runs in clad steel as well as root runs in Nitrogen alloyed fully austenitic steels to avoid hot cracking

FLUX CHARACTERISTICS

Current type	DC (+/-)
Basicity (Boniszewski)	1.6
Solidification speed	High
Density (kg/dm ³)	1.2
Grain size (ISO 14174)	1-16

PACKAGING AND AVAILABLE SIZES

Unit	Net weight (kg)
Bag	25
Sahara ReadyBag™ (SRB)	25