

# LINCOLNWELD® P2000™

Stainless & Nickel ▪ ENISO 760 – S A AF 2

## KEY FEATURES

- Neutral basic flux designed for welding stainless steel and nickel alloys
- Produces sound welds with excellent slag removal and bead appearance
- Exhibits superior resistance to moisture pickup
- Nickel overlays applications
- Stainless overlay and joining applications

## CONFORMANCES

AWS ENISO 760 - S A AF 2

## TYPICAL APPLICATIONS

- For submerged arc welding of stainless steel and nickel alloys

## PACKAGING

50 lb. (22.7 kg) Plastic Bag ED034290

## DEPOSIT COMPOSITION<sup>(1)</sup>

	%C	%Mn	%Si	%Cr	%Ni	%Mo	%P	%S
<b>Lincolnweld® P2000<sup>(2)</sup></b>								
With Lincolnweld® 308/308L	0.018	1.24	0.631	19.34	9.86	0.04	0.03	0.007
With Lincolnweld® 309/309L	0.014	1.23	0.569	23.18	13.27	0.11	0.02	0.007
With Lincolnweld® 316/316L	0.014	1.30	0.568	18.25	12.00	2.69	0.015	0.013

<sup>(1)</sup> Typical all weld metal. <sup>(2)</sup> See test results disclaimer NOTE: There are not AWS requirements for submerged arc stainless steel deposits.

IMPORTANT: SPECIAL VENTILATION AND/OR EXHAUST REQUIRED

Fumes from the normal use of some welding products can contain significant quantities of components - such as chromium and manganese - which can lower the 5.0 mg/m<sup>3</sup> maximum exposure guideline for general welding fume.

BEFORE USE, READ AND UNDERSTAND THE SAFETY DATA SHEET (SDS) FOR THIS PRODUCT AND SPECIFIC INFORMATION PRINTED ON THE PRODUCT CONTAINER.

# LINCOLNWELD® P2007™

Stainless & Nickel ▪ ENISO 760 – S A AF 2

## KEY FEATURES

- Neutral basic flux designed for welding stainless steel and nickel alloys
- Produces sound welds with excellent slag removal and bead appearance
- Exhibits superior resistance to moisture pickup
- Nickel overlays applications
- Stainless overlay and joining applications

## TYPICAL APPLICATIONS

- For submerged arc welding of the 300 and 400 series stainless steels, nickel alloys and similar alloy filler metal

## PACKAGING

50 lb (22.7 kg) Plastic Bag ED033159

## MECHANICAL PROPERTIES<sup>(1)</sup>

	Yield Strength <sup>(2)</sup> MPa (ksi)	Tensile Strength MPa (ksi)	Elongation %	Ferrite Number
<b>Lincolnweld® P2007<sup>(3)</sup></b>				
With Lincolnweld® 308/308L	380 (55)	565 (82)	42	10
With Lincolnweld® 309/309L	400 (58)	570 (83)	35	8
With Lincolnweld® 316/316L	380 (55)	550 (80)	42	9

## DEPOSIT COMPOSITION<sup>(1)</sup>

	%C	%Mn	%Si	%Cr	%Ni	%Mo	%P	%S
<b>Lincolnweld® P2007<sup>(3)</sup></b>								
With Lincolnweld® 308/308L	0.02	1.52	0.63	18.83	9.67	0.13	0.02	0.01
With Lincolnweld® 309/309L	0.03	1.71	0.59	23.58	13.35	0.09	0.02	<0.01
With Lincolnweld® 316/316L	0.02	1.36	0.58	18.04	11.50	2.14	0.02	0.01

<sup>(1)</sup>Typical all weld metal. <sup>(2)</sup>Measured with 0.2% offset. <sup>(3)</sup>See test results disclaimer  
NOTE: There are no AWS requirements for submerged arc stainless steel deposits.

IMPORTANT: SPECIAL VENTILATION AND/OR EXHAUST REQUIRED

Fumes from the normal use of some welding products can contain significant quantities of components - such as chromium and manganese - which can lower the 5.0 mg/m<sup>3</sup> maximum exposure guideline for general welding fume.

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# LINCOLNWELD® ST-100™

Stainless ▪ ENISO 760 – S A AS 2

## KEY FEATURES

- An alloy flux designed for use with solid stainless steel electrodes to compensate for chromium in the wire that is not recovered in the weld deposit
- Excellent slag removal characteristics
- Good performance on seamer applications

## TYPICAL APPLICATIONS

- General submerged arc welding of common austenitic stainless steels such as 304, 304L, 316, 316L, 309 and 347

## PACKAGING

60 lb (27.2 kg) Plastic Bag      ED031856

## MECHANICAL PROPERTIES<sup>(1)</sup>

	Yield Strength <sup>(2)</sup> MPa (ksi)	Tensile Strength MPa (ksi)	Elongation %	Ferrite Number
<b>Lincolnweld® ST-100<sup>(3)</sup></b>				
With Lincolnweld® 308/308L	405 (59)	600 (87)	38	10
With Lincolnweld® 309/309L	415 (60)	585 (85)	37	14
With Lincolnweld® 316/316L	415 (60)	585 (85)	40	10

## DEPOSIT COMPOSITION<sup>(1)</sup>

	%C	%Mn	%Si	%Cr	%Ni	%Mo
<b>Lincolnweld® ST-100<sup>(3,4)</sup></b>						
With Lincolnweld® 308/308L Groove Weld	0.01 0.02	1.9 2.1	0.50 0.70	19.6 19.6	9.8 9.7	0.10 0.10
With Lincolnweld® 309/309L Groove Weld	0.02 0.03	2.1 2.3	0.40 0.60	23.8 24.1	13.7 13.6	0.10 0.10
With Lincolnweld® 316/316L Groove Weld	0.02 0.02	1.7 1.7	0.45 0.65	19.0 18.8	11.9 11.8	2.20 2.20

<sup>(1)</sup>Typical all weld metal. <sup>(2)</sup>Measured with 0.2% offset. <sup>(3)</sup>See test results disclaimer <sup>(4)</sup>Results shown are typical wire compositions for the Lincolnweld® subarc wires listed, and typical weld deposit composition for 1 in groove welds on matching plate. NOTE: There are no AWS requirements for submerged arc stainless steel deposits.

IMPORTANT: SPECIAL VENTILATION AND/OR EXHAUST REQUIRED

Fumes from the normal use of some welding products can contain significant quantities of components - such as chromium and manganese - which can lower the 5.0 mg/m<sup>3</sup> maximum exposure guideline for general welding fume.

BEFORE USE, READ AND UNDERSTAND THE SAFETY DATA SHEET (SDS) FOR THIS PRODUCT AND SPECIFIC INFORMATION PRINTED ON THE PRODUCT CONTAINER.