

# LNM 12

## CLASSIFICATION

AWS A5.28	ER70S-A1	A-Nr	2	Mat-Nr	1.5424
EN ISO 14341-A	G 46 3 M 2Mo	F-Nr	6		
		9606 FM	1/3		

## GENERAL DESCRIPTION

Solid wire for welding creep resistant 0.5%Mo steels and Fine grained steels for low temperature applications in the as welded condition with service temperatures in range -30°C to +500°C

## WELDING POSITIONS (ISO/ASME)



PA/1G



PB/2F



PC/2G



PD/4F



PE/4G



PF/3Gu

## SHIELDING GASES (ACC. ISO 14175)

M21	Mixed gas Ar+ >15-25% CO <sub>2</sub>
C1	Active gas 100% CO <sub>2</sub>

## APPROVALS

TÜV

+

## CHEMICAL COMPOSITION (W%) TYPICAL WIRE

C	Mn	Si	Mo
0.1	1.12	0.6	0.5

## MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Shielding gas	Condition	Yield strength [N/mm <sup>2</sup> ]	Tensile strength [N/mm <sup>2</sup> ]	Elongation [%]	Impact ISO-V(J)	
						+20°C	-20°C
Typical values	M21	AW	503	606	24	130	74

## EXAMPLES OF MATERIALS TO BE WELDED

Steel grades	Standard	Type
Elevated temperature steel	EN 10028-2	P295 G H, P355 G H, 16 Mo 2
EN 10222-2	17 Mo 3, 14 Mo 6	
Fine grained steels	EN 10025 part 3	S275, S355, S420, S460
EN 10025 part 4	S275, S355, S420, S460	

## APPLICATION ADVICE

Preheating welding joint acc.EN 1011-1  
Stress relieving 580-650°C if necessary

## PACKAGING AND AVAILABLE SIZES

Diameter [mm]	0.8	1.0	1.2
15 Kg spool B300	X	X	X
Other sizes and packaging on request			

LNM 12 rev. C-EN26-01/02/16