

LNT 20

CLASSIFICATION

AWS A5.28	ER90S-B3*	A-Nr	4	Mat-Nr	1.7384
ISO 21952-A	W CrMo2Si	F-Nr	6		
* Nearest classification		9606 FM	4		

GENERAL DESCRIPTION

Solid rod for welding creep and hydrogen resistant Cr-Mo steels [2,25Cr - 1Mo]

Service temperature up to 600°C

SHIELDING GASES (ACC. ISO 14175)

II Inert gas Ar (100%)

CHEMICAL COMPOSITION (W%) TYPICAL WIRE

C	Mn	Si	Cr	Mo
0.08	1.0	0.6	2.5	1.0

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Shielding gas	Condition	Yield strength (N/mm ²)	Tensile strength (N/mm ²)	Elongation (%)	Impact ISO-V(J) +20°C
Typical values	II	PWHT 700°C/1h	560	640	22	140

EXAMPLES OF MATERIALS TO BE WELDED

Steel grades	Standard	Type
Creep and hydrogen resistant steels	EN 10028-2	10CrMo 9-10
EN 10222-2	12CrMo 9-10	

APPLICATION ADVICE

Preheating welding joint acc. EN 1011-1, 200-250°C

Post weld heat treatment at 690-740°C

PACKAGING AND AVAILABLE SIZES

Diameter [mm]	2.0	2.4	
5 kg PE-Tube	X	X	<i>Note : Cut length = 1000 mm</i>

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