

# 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		
EN ISO 21952-A	G MoSi	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

Typical values	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
	M21	AW	503	606	24	130	74

## EXAMPLES OF MATERIALS TO BE WELDED

Steel grades	Standard	Type
General structural steels	EN 10025	S355
Pipe material	API 5LX	X52, X56, X60, X65
	EN 10208-2	L360, L415, L445
Low temperature steels	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 3/4	S275, S355, S420, S460

## REMARKS/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
16 kg spool B300	X	X	X

Other sizes and packaging on request

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