

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 ₂
C1	Active gas 100% CO ₂

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 ²)	Tensile strength (N/mm ²)	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

LNM 12 :rev. C-EN28-17/01/20