

# LNM MoNiVa

## CLASSIFICATION

AWS A5.28	ER110S-G	A-Nr	12
EN ISO 16834-A	G 69 4 M Mn3NiCrM	F-Nr	6
		9606 FM	2

## GENERAL DESCRIPTION

Solid wire for welding high strength steels with yield strength up to 690 N/mm<sup>2</sup>  
Good impact values at -40°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>

## APPROVALS

ABS	DB	TÜV	CE
+	+	+	+

## CHEMICAL COMPOSITION (W%) TYPICAL WIRE

C	Mn	Si	Ni	Cr	Mo	V	Cu
0.08	1.7	0.44	1.35	0.23	0.3	0.08	0.25

## MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

Typical values	Shielding gas	Condition	Yield strength	Tensile strength	Elongation	Impact ISO-V(J)
			(N/mm <sup>2</sup> )	(N/mm <sup>2</sup> )	(%)	-40°C
	M21	AW	710	790	20	70

## EXAMPLES OF MATERIALS TO BE WELDED

Steel grades	Standard	Type
Pipe material	API-5LX	X65, X70, X80
	EN 10208-2	L480, L550
Fine grained steels	EN 10025 part 6	S460, S500, S550, S620 S690
		S620GI1, S600MC, TstE620, Weldox 500, Hardox

## 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 MoNiVa rev. C-EN28-01/2/16