

LNM 19

CLASSIFICATION

AWS A5.28	ER80S-B2*	A-Nr	3	Mat-Nr	1.7339
ISO 21952-A	G CrMo1Si	F-Nr	6		
* Nearest classification		9606 FM	3		

GENERAL DESCRIPTION

Solid wire for welding creep and hydrogen resistant Cr-Mo steels [1,25Cr - 0,5Mo]
Service temperature up to 550°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 Mixed gas
M13	Mixed gas Ar+ >0.5-3% O ₂

APPROVALS

TÜV

+

CHEMICAL COMPOSITION (W%) TYPICAL WIRE

C	Mn	Si	Cr	Mo
0.1	1.0	0.5	1.2	0.5

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	M21	PWHT 700°C/1h	530	635	23	160

EXAMPLES OF MATERIALS TO BE WELDED

Steel grades	Standard	Type
Elevated temperature steel	EN 10028-2	13 CrMo4-5
EN 10083-1	25 CrMo 4	
EN 10222-2	14 CrMo 4-5	
Tool steel	DIN 17210	16 MnCr 5

APPLICATION ADVICE

Preheating welding joint acc. EN 1011-1, 200-250°C
Post weld heat treatment at 660-700°C

PACKAGING AND AVAILABLE SIZES

Diameter (mm)	1.0	1.2
16 kg spool B300	X	X
Other sizes and packaging on request		

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