

LNM 4M

CLASSIFICATION

EN 14700 S Fe2 Mat-Nr 1.8405

GENERAL DESCRIPTION

Solid wire for hardfacing applications
 Hardness approximately HB 325-375
 Optimal welding characteristics
 Martensitic structure

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% CO₂

CHEMICAL COMPOSITION (W%) TYPICAL WIRES

C	Mn	Si	Cr
0.7	1.9	0.5	1.0

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

2 Layers, AW
 Typical hardness values
 : approx. 38 HRC

APPLICATION

Forming dies
 Dies
 Impact resistance tools

PACKAGING AND AVAILABLE SIZES

Diameter [mm]	1.2
15 kg spool B300	X
Other sizes and packaging on request	

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