

# LNM MoNi

## CLASSIFICATION

AWS A5.28	ER1005-G	A-Nr	12
EN ISO 16834-A	G 62 4 M Mn3NiCrMo	F-Nr	6
		9606 FM	2

## GENERAL DESCRIPTION

Solid wire for welding high strength steels with a yield up to 620 Mpa  
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>

## CHEMICAL COMPOSITION (W%) TYPICAL WIRE

C	Mn	Si	Ni	Cr	Mo	Cu
0.10	1.65	0.75	0.55	0.60	0.30	0.08

## MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Shielding gas	Condition	Yield strength (N/mm <sup>2</sup> )	Tensile strength (N/mm <sup>2</sup> )	Elongation (%)	Impact ISO-V(J)		
						-20°C	-40°C	-60°C
Typical values	M21	AW	635	770	19	100	90	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 S620GH, S600MC, TstE620, Weldox 500, Hardox

## PACKAGING AND AVAILABLE SIZES

Diameter (mm)	1.0	1.2
16 kg spool B300	X	X

Other sizes and packaging on request

LNM MoNi rev. C-EN26-05/06/17