

LNM Ni2.5

CLASSIFICATION

AWS A5.28	ER80S-Ni2	A-Nr	10
EN ISO 14341-A	G 46 6 M 2Ni2	F-Nr	6
		9606 FM	1/2

GENERAL DESCRIPTION

Solid wire for welding fine grained and low alloy nickel steels
 High impact value at low temperature [-60°C as welded and -90°C after stress relieving 15h/580°C].
 Typical offshore applications

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

APPROVALS

TÜV

+

CHEMICAL COMPOSITION (W%) TYPICAL WIRE

C	Mn	Si	Ni
0.1	1.1	0.55	2.4

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Shielding gas	Condition	Yield strength (N/mm ²)	Tensile strength (N/mm ²)	Elongation (%)	Impact ISO-V(J) -60°C
Typical values	M21	AW	490	580	24	85

EXAMPLES OF MATERIALS TO BE WELDED

Steel grades	Standard	Type
General structural steels	EN 10025	S355
Pipe material	API-5LX EN 10208-2	X52, X56, X60, X65 L360, L415, L445
Fine grained steels	EN 10025 part 3/4	S355, S420, S460
Low temperature steels	EN 10028-4 EN 10222-3	11 MnNi 5-3, 13 MnNi 6-3, 15 NiMn 6 [12 Ni 14 G 1, G 2] 13 MnNi 6-3, 15 NiMn 6

PACKAGING AND AVAILABLE SIZES

Diameter (mm)	1.0	1.2
15 Kg spool B300	X	X
Other sizes and packaging on request		

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