

# LNT 19

## CLASSIFICATION

AWS A5.28 - ER80S-B2\*  
ISO 21952-A - W CrMo1Si

\* Nearest classification

## GENERAL DESCRIPTION

Solid rod for welding creep and hydrogen resistant Cr-Mo steels (1,25Cr - 0,5Mo)  
Service temperature up to 550°C

## SHIELDING GASES (ACC. ISO 14175)

I1 Inert gas Ar (100%)

## APPROVALS

TÜV

+

## CHEMICAL COMPOSITION (W%) TYPICAL WIRE

C	Mn	Si	Cr	Mo
0.1	1.0	0.6	1.2	0.5

## 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
Typical values	I1	PWHT 700°C/1h	540	640	22	250

## 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

## PACKAGING AND AVAILABLE SIZES

	Diameter (mm)	2.0	2.4	3.0
Unit:	5 kg PE-Tube	X	X	X

Note: Cut length = 1000 mm

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