

LNT 20

CLASSIFICATION

AWS A5.28 - ER90S-B3*
ISO 21952-A - W CrMo2Si

* Nearest classification

GENERAL DESCRIPTION

Solid rod for welding creep and hydrogen resistant Cr-Mo steels (2,25Cr - 1Mo)
Service temperature up to 600°C

SHIELDING GASES (ACC. ISO 14175)

I1 Inert gas Ar (100%)

CHEMICAL COMPOSITION (W%) TYPICAL WIRE

C	Mn	Si	Cr	Mo
0.08	1.0	0.6	2.5	1.0

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	-10°C
Typical values	I1	AW	460	605	23	140	141

MATERIALS TO BE WELDED

Steel grades	Standard	Type
Creep and hydrogen resistant steels	EN 10028-2	10CrMo 9-10
	EN 10222-2	12CrMo 9-10

APPLICATION ADVICE

Preheating welding joint acc. EN 1011-1, 200-250°C
Post weld heat treatment at 690-740°C

PACKAGING AND AVAILABLE SIZES

Diameter (mm)	2.0	2.4	3.0
Unit : 2 & 5 kg tube	X	X	X

Other sizes and packaging on request

Note : Cut length = 1000 mm

LNT 20: rev. EN 23

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Fumes: Material Safety Data Sheets (MSDS) are available on our website.