

LNT 4465

CLASSIFICATION

ISO 14343-A - W 25 22 2 N L

GENERAL DESCRIPTION

Solid rod for welding high CrNiMo-alloyed austenitic steels of type 25/22/2
Excellent resistance to strong oxidizing and moderate reducing conditions
Especially for urea applications

SHIELDING GASES (ACC. ISO 14175)

I1 Inert gas Ar (100%)

APPROVALS

TÜV

+

CHEMICAL COMPOSITION (W%) TYPICAL WIRE

C	Mn	Si	Cr	Ni	Mo	N
0.01	4.5	0.2	25	23	2.0	0.15

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Shielding gas	Condition	0.2% proof strength (N/mm ²)	Tensile strength (N/mm ²)	Elongation (%)	Impact ISO-V(J) -10°C
Typical values	I1	AW	360	620	30	80

MATERIALS TO BE WELDED

Steel grades	EN 10088-1/-2	Mat. Nr	ASTM/AISI	UNS
Fully austenitic corrosion resistant CrNiMo steels				
	X1 CrNiMoN 25-25-2	1.4465		
	X3 CrNiMoTi 25-25	1.4577		
	X2 CrNi 19-11	1.4306	(TP)304L	S30403
			CF-3	J92500
	X2 CrNiN 18-10	1.4311	(TP)304LN	S30453
			310S	S31008

Also very well applicable for build-up welding on low alloyed steel, such as pipe plates
 Buffer layer -120 ...+350°C

PACKAGING AND AVAILABLE SIZES

Diameter (mm)	2.0	2.4
Unit :	2 & 5 kg tube	X X
Other sizes and packaging on request		

LNT 4465; rev. EN 22