

# LNM 19

## CLASSIFICATION

<b>AWS A5.28</b>	ER80S-B2*	<b>A-Nr</b>	3	<b>Mat-Nr</b>	1.7339
<b>ISO 21952-A</b>	G CrMo1Si	<b>F-Nr</b>	6		
* Nearest classification		<b>9606 FM</b>	3		

## GENERAL DESCRIPTION

Solid wire for welding creep and hydrogen resistant Cr-Mo steels [1,25Cr - 0,5Mo]  
Service temperature up to 550°C

## WELDING POSITIONS (ISO/ASME)



PA/1G



PB/2F



PC/2G



PD/4F



PE/4G



PF/3Gu

## SHIELDING GASES (ACC. ISO 14175)

<b>M21</b>	Mixed gas Ar+ >15-25% CO <sub>2</sub>
<b>C1</b>	Active gas 100% CO <sub>2</sub> Mixed gas
<b>M13</b>	Mixed gas Ar+ >0.5-3% O <sub>2</sub>

## APPROVALS

TÜV

+

## CHEMICAL COMPOSITION (W%) TYPICAL WIRE

C	Mn	Si	Cr	Mo
0.1	1.0	0.5	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
<b>Typical values</b>	M21	PWHT 700°C/1h	530	635	23	160

## EXAMPLES OF MATERIALS TO BE WELDED

Steel grades	Standard	Type
<b>Elevated temperature steel</b>	EN 10028-2	13 CrMo4-5
EN 10083-1	25 CrMo 4	
EN 10222-2	14 CrMo 4-5	
<b>Tool steel</b>	DIN 17210	16 MnCr 5

## APPLICATION ADVICE

Preheating welding joint acc. EN 1011-1, 200-250°C  
Post weld heat treatment at 660-700°C

## PACKAGING AND AVAILABLE SIZES

Diameter (mm)	1.0	1.2
<b>16 kg spool B300</b>	X	X

Other sizes and packaging on request

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