

LNМ Ni1

CLASSIFICATION

AWS A5.28	ER80S-Ni1	A-Nr	10
EN ISO 14341-A	G 46 5 M 3Ni1	F-Nr	6
		9606 FM	2

GENERAL DESCRIPTION

Solid wire for welding fine grained and low alloy nickel steels

High impact value at low temperature [-60°C]

Typical offshore applications

Stable arc and excellent feedability

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

DB	TÜV
+	+

CHEMICAL COMPOSITION (W%) TYPICAL WIRE

C	Mn	Si	Ni
0.09	1.2	0.6	0.9

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

Typical values	Shielding gas	Condition	Yield strength	Tensile strength	Elongation	Impact ISO-V(J)
			(N/mm ²)	(N/mm ²)	(%)	-60°C
	M21	AW	480	580	30	60

EXAMPLES OF MATERIALS TO BE WELDED

Steel grades	Standard	Type
General structural steels	EN 10025	S275, S355
Ship plates	ASTM A131	ASTM A131
Cast steels	EN 10213-2	GP240R
Pipe material	EN 10208-1	L290 GA, L360GA
	EN 10208-2	L290, L360, L415
	API 5LX	X42, X46, X52, X60, X65
	EN 10216-1	P275T1
	EN 10217-1	P275 T2, P355 N
Fine grained steels	EN 10025 part 3/4	S275, S355, S420, S460
	EN 10028	P355NL-1, P460NL-1

PACKAGING AND AVAILABLE SIZES

Diameter (mm)	1.0	1.2
5 kg plastic spool S200	X	
15 Kg spool B300	X	X
Other sizes and packaging on request		

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