

LNT 12

CLASSIFICATION

AWS A5.28	ER70S-A1	A-Nr	2	Mat-Nr	1.5424
ISO 21952-A	W MoSi	F-Nr	6		
EN ISO 636	W 46 3 W2Mo	9606 FM	1/3		

GENERAL DESCRIPTION

Solid rod for welding creep resistant 0.5%Mo steels and Fine grained steels for low temperature applications in the as welded condition with service temperatures in range -20°C to +500°C

SHIELDING GASES (ACC. ISO 14175)

I1 Inert gas Ar (100%)

APPROVALS

TÜV	DNV	GL	DB
+	+	+	+

CHEMICAL COMPOSITION (W%) TYPICAL WIRE

C	Mn	Si	Mo
0.1	1.2	0.6	0.5

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	-20°C
Typical values	I1	AW	635	670	22	170	110

EXAMPLES OF MATERIALS TO BE WELDED

Steel grades	Standard	Type
General structural steels	EN 10025	S355
Pipe material	API 5LX	X52, X56, X60, X65
	EN 10208-2	L360, L415, L445
Low temperature steels	EN 10028-2	P295 G H, P355 G H, 16 Mo 2
	EN 10222-2	17 Mo 3, 14 Mo 6
Fine grained steels	EN 10025 part 3/4	S275, S355, S420, S460

REMARKS/APPLICATION ADVICE

- Preheating welding joint acc.EN 1011-1
- Stress relieving 580-650°C if necessary

PACKAGING AND AVAILABLE SIZES

Diameter (mm)	1.6	2.0	2.4	3.0	<i>Note : Cut length = 1000 mm</i>
5 kg PE-Tube	X	X	X	X	

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