LNT Ni1

CLASSIFICATION

AWS A5.28	: ER80S-Ni1
EN ISO 636-A	: W 42 6 W3Ni1

GENERAL DESCRIPTION

Solid rod for welding fine grained and low alloy nickel steels
High impact value at low temperature (-60°C)
Typical offshore applications

SHIELDING GASES (ACC. ISO 14175)

I1	Inert gas Ar (100%)

APPROVALS

GL	TÜV	CE	DNV
+	+	+	+

CHEMICAL COMPOSITION (W%) TYPICAL WIRE

C	Mn	Si	Ni
0.1	1.2	0.6	0.9

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Shielding gas	Condition	Yield strength (N/mm²)	Tensile strength (N/mm²)	Elongation (%)	Impact ISO-V(J) -60°C
Typical values	I1	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	Grade A, B, D, E, AH32 to EH36
Cast steel	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 steel	EN 10025 part 3	S275, S355, S420, S460
	EN 10025 part 4	S275, S355, S420, S460
	EN 10028	P355NL-1, P460NL-1

PACKAGING AND AVAILABLE SIZES

	Diameter (mm)	1.6	2.0	2.4	3.0
Unit :	5 kg PE-Tube	X	X	X	X

Note : Cut length = 1000 mm

LNT Ni1: rev. C-EN28-22/10/15