

LNM 28

CLASSIFICATION

AWS A5.28	ER80S-G	A-Nr	10
EN ISO 16834-A	G Z Mn3 Ni1 Cu*	F-Nr	6
* Nearest classification		9606 FM	2

GENERAL DESCRIPTION

Solid wire special for welding of weather resisting steels
Contains a small percentage of copper to help preventing further oxidation of the weld bead

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% CO ₂
C1	Active gas 100% CO ₂

CHEMICAL COMPOSITION (W%) TYPICAL WIRE

C	Mn	Si	Ni	Cu
0.1	1.4	0.75	0.8	0.3

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)	(%)	-20°C	-40°C
	M21	AW	570	620	26	90	70

EXAMPLES OF MATERIALS TO BE WELDED

Steel grades	Standard	Type
Weather resisting steels	EN 10155	S 235 J 0 W
		S 235 J 2 W
		S 355 J 0 W
		S 355 J 2 W
		S 355 J 2 G 1 W

PACKAGING AND AVAILABLE SIZES

Diameter (mm)	1.0	1.2
15 Kg spool B300	X	X

Other sizes and packaging on request

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