

# LNМ 28

## CLASSIFICATION

AWS A5.28 - ER80S-G

EN ISO 16834-A - G Z Mn3 Ni1 Cu\*

\* Nearest classification

## 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/3G up

## SHIELDING GASES (ACC. ISO 14175)

M21

Mixed gas Ar+ >15-25% CO<sub>2</sub>

C1

Active gas 100% CO<sub>2</sub>

## 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

	Shielding gas	Condition	Yield strength (N/mm <sup>2</sup> )	Tensile strength (N/mm <sup>2</sup> )	Elongation (%)	Impact ISO-V(J)	
						-20°C	-40°C
Typical values	M21	AW	570	620	26	90	70

## 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 K 2 G 1 W

## PACKAGING AND AVAILABLE SIZES

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

Other sizes and packaging on request

LNМ 28: rev. EN 23