

LNT Ni2.5

CLASSIFICATION

AWS A5.28	ER80S-Ni2	A-Nr	10
EN ISO 636-A	W2 Ni2	F-Nr	6
		9606 FM	1

GENERAL DESCRIPTION

Solid rod for welding fine grained and low alloy nickel steels

High impact value at low temperature [-60°C as welded and -90°C after stress relieving 15h/580°C].

Typical offshore applications

SHIELDING GASES (ACC. ISO 14175)

II Inert gas Ar (100%)

APPROVALS

TÜV	CE
+	+

CHEMICAL COMPOSITION (W%) TYPICAL WIRE

C	Mn	Si	Ni
0.1	1.1	0.55	2.4

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Shielding gas	Condition	Yield strength (N/mm ²)	Tensile strength (N/mm ²)	Elongation (%)	Impact ISO-V(J)	
						-62°C	-90°C
Typical values	II	AW	525	605	28	280	133

EXAMPLES OF MATERIALS TO BE WELDED

Steel grades	Standard	Type
General structural steels	EN 10025	S355
Pipe material	EN 10208-2	L360, L415, L445
API 5 LX	X52, X56, X60, X65	
Fine grained steels	EN 10025 part 3	S355, S420, S460
EN 10025 part 4	S355, S420, S460	
Low temperature steels	EN 10028-4	11 MnNi 5-3, 13 MnNi 6-3, 15 NiMn 6
	(12 Ni 14 G 1, G 2)	
EN 10222-3	13 MnNi 6-3, 15 NiMn 6	

PACKAGING AND AVAILABLE SIZES

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

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