

LNM 19







CLASSIFICATION

AWS A5.28 - ER80S-B2*
ISO 21952-A - G CrMo1Si

GENERAL DESCRIPTION

Solid wire for welding creep and hydrogen resistant Cr-Mo steels (1,25Cr - 0,5Mo)
Service temperature up to 550°C

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 ₂
C1	Active gas 100% CO ₂

APPROVALS

TÜV

+

CHEMICAL COMPOSITION (W%) TYPICAL WIRE

C	Mn	Si	Cr	Mo
0.1	1.0	0.5	1.2	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)
Typical values	M21	AW	315	610	29	-10°C 97

MATERIALS TO BE WELDED

Steel grades	Standard	Type
Elevated temperature steel	EN 10028-2	13 CrMo4-5
	EN 10083-1	25 CrMo 4
	EN 10222-2	14 CrMo 4-5
Tool steel	DIN 17210	16 MnCr 5

APPLICATION ADVICE

Preheating welding joint acc.EN 1011-1,200-250°C
Post weld heat treatment at 660-700°C

PACKAGING AND AVAILABLE SIZES

Diameter (mm)	0.8	1.0	1.2	1.6
Unit : 15 Kg spool B300	X	X	X	X
Other sizes and packaging on request				

LNM 19 rev. EN 24

All information in this data sheet is accurate to the best of our knowledge at the time of printing. Please refer to www.lincolnelectric.eu for any updated information.
Fumes: Material Safety Data Sheets (MSDS) are available on our website.