

# LNT Ni1

## CLASSIFICATION

AWS A5.28	ER80S-Ni1	A-Nr	10
EN ISO 636-A	W 42 6 W3Ni1	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]  
 Typical offshore applications

## SHIELDING GASES (ACC. ISO 14175)

II 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/mm <sup>2</sup> )	Tensile strength (N/mm <sup>2</sup> )	Elongation (%)	Impact ISO-V(J) -60°C
Typical values	II	AW	480	580	30	60

## EXAMPLES OF MATERIALS TO BE WELDED

Steel grades	Standard	Type
<b>General structural steels</b>	EN 10025	S275, S355
<b>Ship plates</b>	ASTM A131	Grade A, B, D, E, AH32 to EH36
<b>Cast steels</b>	EN 10213-2	GP240R
<b>Pipe material</b>	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	
<b>Fine grained steels</b>	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	Note : Cut length = 1000 mm
5 kg PE-Tube	X	X	X	X	

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