

LNM 20

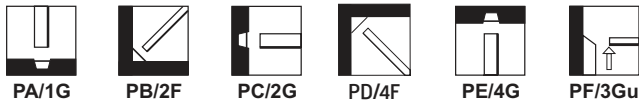
CLASSIFICATION

AWS A5.28	ER90S-B3*	A-Nr	4	Mat-Nr	1.7384
ISO 21952-A	G CrMo2Si	F-Nr	6		
* Nearest classification		9606 FM	3		

GENERAL DESCRIPTION

Solid wire for welding creep and hydrogen resistant Cr-Mo steels (2,25Cr - 1Mo)
Service temperature up to 600°C

WELDING POSITIONS (ISO/ASME)



SHIELDING GASES (ACC. ISO 14175)

M21	Mixed gas Ar+ >15-25% CO ₂
C1	Active gas 100% CO ₂
M13	Mixed gas Ar+ >0-3% CO ₂

CHEMICAL COMPOSITION (W%) TYPICAL WIRE

C	Mn	Si	Cr	Mo
0.08	0.9	0.6	2.5	1.0

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Shielding gas	Condition	Yield strength (N/mm ²)	Tensile strength (N/mm ²)	Elongation (%)	Impact ISO-V(J)
						+20°C
Typical values	M21	PWHT 690°C/1h	560	680	20	100

EXAMPLES OF MATERIALS TO BE WELDED

Steel grades	Standard	Type
Creep and hydrogen resistant steels	EN 10028-2	10CrMo 9-10
EN 10222-2	12CrMo 9-10Inm 304I	

APPLICATION ADVICE

Preheating welding joint acc. EN 1011-1, 200-250°C
Post weld heat treatment at 690-740°C

PACKAGING AND AVAILABLE SIZES

Diameter [mm]	1.0	1.2
15 Kg spool B300	X	X
Other sizes and packaging on request		

LNM 20 rev. C-EN26-01/02/16