

# LNM Ni1

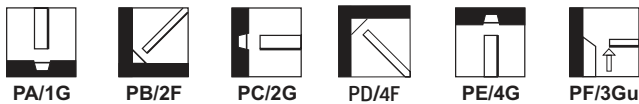
## CLASSIFICATION

AWS A5.28	ER80S-Ni1	A-Nr	10
EN ISO 14341-A	G 46 5 M 3Ni1	F-Nr	6
		9606 FM	2

## GENERAL DESCRIPTION

Solid wire for welding fine grained and low alloy nickel steels  
 High impact value at low temperature (-60°C)  
 Typical offshore applications  
 Stable arc and excellent feedability

## WELDING POSITIONS (ISO/ASME)



## SHIELDING GASES (ACC. ISO 14175)

M21 Mixed gas Ar+ >15-25% CO<sub>2</sub>

## APPROVALS

DB	TÜV
+	+

## CHEMICAL COMPOSITION (W%) TYPICAL WIRE

C	Mn	Si	Ni
0.09	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	M21	AW	480	580	30	60

## EXAMPLES OF MATERIALS TO BE WELDED

Steel grades	Standard	Type
General structural steels	EN 10025	S275, S355
Ship plates	ASTM A131	ASTM A131
Cast steels	EN 10213-2	GP240R
Pipe material	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
Fine grained steels	EN 10025 part 3/4	S275, S355, S420, S460
	EN 10028	P355NL-1, P460NL-1

## PACKAGING AND AVAILABLE SIZES

Diameter (mm)	1.0	1.2
5 kg plastic spool S200	X	
15 Kg spool B300	X	X
Other sizes and packaging on request		

LNM Ni1 :rev. C-EN27-01/02/16

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](http://www.lincolnelectric.eu) for any updated information.  
 Fumes: Safety Data Sheets (SDS) are available on our website.