

# LNM 28

## CLASSIFICATION

|                          |                 |                |    |
|--------------------------|-----------------|----------------|----|
| <b>AWS A5.28</b>         | ER80S-G         | <b>A-Nr</b>    | 10 |
| <b>EN ISO 16834-A</b>    | G Z Mn3 Ni1 Cu* | <b>F-Nr</b>    | 6  |
| * Nearest classification |                 | <b>9606 FM</b> | 2  |

## GENERAL DESCRIPTION

Solid wire special for welding of weather resisting steels

Contains a small percentage of copper to help preventing further oxidation of the weld bead

## WELDING POSITIONS (ISO/ASME)



PA/1G



PB/2F



PC/2G



PD/4F



PE/4G



PF/3Gu

## SHIELDING GASES (ACC. ISO 14175)

|            |                                       |
|------------|---------------------------------------|
| <b>M21</b> | Mixed gas Ar+ >15-25% CO <sub>2</sub> |
| <b>C1</b>  | Active gas 100% CO <sub>2</sub>       |

## CHEMICAL COMPOSITION (W%) TYPICAL WIRE

| C   | Mn  | Si   | Ni  | Cu  |
|-----|-----|------|-----|-----|
| 0.1 | 1.4 | 0.75 | 0.8 | 0.3 |

## MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

|                | Shielding gas | Condition | Yield strength<br>(N/mm <sup>2</sup> ) | Tensile strength<br>(N/mm <sup>2</sup> ) | Elongation<br>(%) | Impact ISO-V(J) |       |
|----------------|---------------|-----------|--|--|-------------------|-----------------|-------|
|                |               |           |  |  |                   | -20°C           | -40°C |
| Typical values | M21           | AW        | 570                                    | 620                                      | 26                | 90              | 70    |

## EXAMPLES OF MATERIALS TO BE WELDED

| Steel grades             | Standard | Type            |
|--------------------------|----------|-----------------|
| Weather resisting steels | EN 10155 | S 235 J 0 W     |
|                          |          | S 235 J 2 W     |
|                          |          | S 355 J 0 W     |
|                          |          | S 355 J 2 W     |
|                          |          | S 355 K 2 G 1 W |

## PACKAGING AND AVAILABLE SIZES

| Diameter [mm]    | 1.0 | 1.2 |
|------------------|-----|-----|
| 16 kg spool B300 | X   | X   |

Other sizes and packaging on request

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