

LNT/LNM Ni 2.5

Low alloy solid wire

Classification

AWS A5.28-96	:	ER80S-Ni2
EN 1668-97	:	W 46 6 W2Ni2
EN 440-94	:	G 46 6 M G2Ni2

General description

Solid wire for welding fine grained and low alloyed nickel steels
High impact value at low temperature (-70°C).
Typical offshore applications

Shielding gases (acc. EN 439)

GTAW	I1	Inert gas Ar (100%)
GMAW	M21	Mixed Gas Ar+ >5% to 25 CO ₂

Approvals

	TÜV
GTAW	+
GMAW	+

Chemical composition (w%), typical, wire / rod

C	Mn	Si	Ni
0.1	1.1	0.6	2.5

Mechanical properties, typical, all weld metal

	Process	Shielding gas	Condition	Yield strength (N/mm ²)	Tensile strength (N/mm ²)	Elongation (%)	Impact ISO-(VJ)		
							-62°C	-70°C	-90°C
Typical values	GTAW	I1	AW	480	620	24		80	60
	GTAW	I1	SR 620°C/1 h	540	640	25			50
	GMAW	M21	AW	510	620	22		90	
	GMAW	M21	SR 620°C/1 h	540	640	25	80		

Materials to be welded

Steel	Code	Type
General structural steel	EN 10025	S355
Pipe material	EN 10208-2	L360, L415, L445
	API 5 LX	X52, X56, X60, X65
Fine grained steel	EN 10113-2	S355, S420
	EN 10113-3	S355, S420
Low temperature steel	EN 10028-4	11 MnNi 5-3, 13 MnNi 6-3, 15 NiMn 6 (12 Ni 14 G 1, G 2)
	EN 10222-3	13 MnNi 6-3, 15 NiMn 6

Packaging

Process	Unit	Sizes (mm)			
		1.0	1.2	2.0	2.4
GTAW	2 and 5 kg tube			X	X
GMAW	15 kg spool B300	X	X		

Other sizes and packaging on request

LNT/LNM Ni 2.5: rev. EN 15

LINCOLN
ELECTRIC

GMAW/GTAW