LNM NiCro 31/27

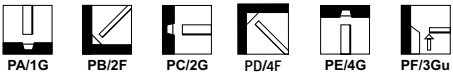
CLASSIFICATION

AWS A5.9	ER383	**A-Nr**	9	**Mat-Nr**	1.4563
ISO 14343-A	G 27 31 4 Cu L	**F-Nr**	6		
		9606 FM	5		

GENERAL DESCRIPTION

Solid wire for welding of Cu-alloyed NiCrMo-steels
Excellent resistance to general corrosion, pitting and stress corrosion in acid and alkaline environments
Especially for applications in phosphoric and sulphuric acid

WELDING POSITIONS (ISO/ASME)



PA/1G **PB/2F** **PC/2G** **PD/4F** **PE/4G** **PF/3Gu**

SHIELDING GASES (ACC. ISO 14175)

I1	Inert gas Ar (100%)
I3	Inert gas Ar+ 0.5-95% He

CHEMICAL COMPOSITION (W%) TYPICAL WIRE

C	Mn	Si	Ni	Cr	Mo	Cu
0.01	1.6	1.0	31	27	3.5	1.0

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Shielding gas	Condition	0.2% proof strength (N/mm²)	Tensile strength (N/mm²)	Elongation (%)	Impact ISO-V(J) +20°C	Impact ISO-V(J) -196°C
Typical values	I1	AW	440	640	38	100	50

EXAMPLES OF MATERIALS TO BE WELDED

Steel grades	EN 10088-1/2	Mat. Nr	ASTM/ACI	UNS
Copper alloy CrNiMo and NiCrMo-steels				
	X1NiCrMoCu31-27-4	1.4563		N08028
	X1NiCrMoCu25-20-5	1.4539	Alloy 904L	N08904
	DIN 17744			
	NiCr 21 Mo	2.4858	Alloy 825	N08825
	NiCr 21 Mo 6Cu	2.6410	Alloy 825 h Mo	N08821
	X3NiCrCuMoTi27-23	1.4503		

PACKAGING AND AVAILABLE SIZES

Diameter (mm)	1.2
15 kg spool BS300	X

Other sizes and packaging on request

LNM NiCro 31/27; rev. C-EN23-01/02/16

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THE WELDING EXPERTS®