LNT NiCro 31/27

CLASSIFICATION

AWS A5.9 - ER383
ISO 14343-A - W 27 31 4 Cu L

GENERAL DESCRIPTION

Solid rod 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

SHIELDING GASES (ACC. ISO 14175)

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

APPROVALS

TÜV

+

CHEMICAL COMPOSITION (W%) TYPICAL WIRE

C	Mn	Si	Ni	Cr	Mo	Cu
0.01	1.5	0.2	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	400	600	35	120	80

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			
	NiCr21Mo	2.4858	Alloy 825	N08825
	NiCr21Mo6Cu	2.6410	Alloy 825 h Mo	N08821
	X3NiCrCuMoTi 27-23	1.4503		

PACKAGING AND AVAILABLE SIZES

Diameter (mm)	2.0
Unit : 2 kg tube	X

Other sizes and packaging on request

Note : Cut length = 1000 mm