

LNM 4465

CLASSIFICATION

ISO 14343-A - G 25 22 2 N L

GENERAL DESCRIPTION

Solid wire for welding high CrNiMo-alloyed austenitic steels of type 25/22/2
Excellent resistance to strong oxidizing and moderate reducing conditions
Especially for urea applications

WELDING POSITIONS

ISO/ASME



PA/1G



PB/2F



PC/2G



PD/4F



PE/4G



PF/3G up

SHIELDING GASES (ACC. ISO 14175)

M12 Mixed gas Ar+ 0.5-5% CO₂
M13 Mixed gas Ar+ 0.5-3% O₂

APPROVALS

TÜV

+

CHEMICAL COMPOSITION (W%) TYPICAL WIRE

C	Mn	Si	Cr	Ni	Mo	N
0.01	4.5	0.2	25	23	2.0	0.15

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Shielding gas	Condition	0.2% proof strength (N/mm ²)	Tensile strength (N/mm ²)	Elongation (%)	Impact ISO-V(J) +20°C
Typical values	M12	AW	360	620	30	80

MATERIALS TO BE WELDED

Steel grades	EN 10088-1/-2	Mat. Nr	ASTM/ACI	UNS
Fully austenitic corrosion resistant CrNiMo steels				
	X1 CrNiMoN 25-25-2	1.4465		
	X3 CrNiMoTi 25-25	1.4577		
	X2 CrNi 19-11	1.4306	(TP)304L	S30403
			CF-3	J92500
	X2 CrNiN 18-10	1.4311	(TP)304LN	S30453
			310S	S31008

Also very well applicable for build-up welding on low alloyed steel, such as pipe plates

Buffer layer -120 ...+350°C

PACKAGING AND AVAILABLE SIZES

Diameter (mm)	0.8	1.0	1.2
Unit : 15 kg spool BS300	X	X	X
Other sizes and packaging on request			

LNM 4465: rev. EN 22