LNT 12

TOP FEATURES

- Used for welding low alloy creep resistant ferritic steels and fine grained steels
- Ideal for low temperature applications in the as welded condition with service temperatures in range -20°C to +500°C

TYPICAL APPLICATIONS

- Chemical
- Petrochemical
- Oil & Gas
- Thermal Power

CLASSIFICATION

AWS A5.28	ER70S-A1
EN ISO 636-A	W 46 3 2Mo
EN ISO 21952-A	W MoSi

APPROVALS

TÜV, DB, CE

SHIELDING GASES (ACC. EN ISO 14175)

I1	Inert gas Ar (100%)

CHEMICAL COMPOSITION (WEIGHT %), TYPICAL

C	Mn	Si	Mo
0.1	1.2	0.6	0.5

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Shielding gas	Condition	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J)	
						+20°C	-20°C
Typical values	I1	AW	530	620	26	170	110
	I1	PWHT 620°C/1h	515	598	26	-	-

AW = As welded, PWHT = Post Weld Heat Treatment

AVAILABLE SIZES AND PACKAGING INFORMATION

Diameter x Length (mm)	Packaging	Weight (kg)	Item number
1.6	PE Tube	5.0	604245
2.0	PE Tube	5.0	604269
2.4	PE Tube	5.0	604283
3.0	PE Tube	5.0	604306

TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application

Safety Data Sheets (SDS) are available here:

Subject to Change – The information is accurate to the best of our knowledge at the time of printing.
Please refer to www.lincolnelectric.eu for any updated information.