

LNM 28

TOP FEATURES

- Solid wire for the welding of weathering steels such as COR-TEN, Patinax, etc.
- Due to the alloying system, it can also be used for welding of high yield strength steels.
- Contains a small percentage of copper to help preventing further oxidation of the weld bead.
- Excellent mechanical characteristics and resistance to corrosion.

TYPICAL APPLICATIONS

- Infrastructures
- Transmission towers, barriers, ducting, chimneys
- Exhaust Systems

CLASSIFICATION

AWS A5.28 ER 80S-G
EN ISO 16834-A G Mn3Ni1Cu*

* Nearest classification

SHIELDING GASES (ACC. EN ISO 14175)

M21 Mixed gas Ar+ 15-25% CO₂
C1 Active gas 100% CO₂

APPROVALS

LR	BV	DNV	DB	CE
+	+	+	+	+

CHEMICAL COMPOSITION (WEIGHT %), TYPICAL, WIRE

C	Mn	Si	Ni	Cu
0.1	1.4	0.75	0.8	0.3

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Shielding gas	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J) -20°C	Impact ISO-V (J) -40°C
Typical values	M21	AW	570	620	25	90	70

* AW = As welded

PACKAGING AND AVAILABLE SIZES

Wire diameter (mm)	Packaging	Weight (kg)	Item number
1.0	SPOOL (B300)	16.0	S10K016PCE01
1.2	SPOOL (B300)	16.0	S12K016PCE01
	DRUM	250.0	S12D250ECS01

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.