

LNM 25

CLASSIFICATION

AWS A5.18/A5.18M - ER70S-3
EN ISO 14341-A - G 42 4 M 2Si

GENERAL DESCRIPTION

Solid wire for welding general construction in mild steel
High impact values
Stable arc and excellent feedability

WELDING POSITIONS

ISO/ASME						
	PA/1G	PB/2F	PC/2G	PD/4F	PE/4G	PF/3G up

SHIELDING GASES (ACC. ISO 14175)

M21	Mixed gas Ar+ >15-25% CO ₂
C1	Active gas 100% CO ₂

APPROVALS

ABS	BV	DNV	GL	LR	TÜV	CE
+	+	+	+	+	+	+

CHEMICAL COMPOSITION (W%) TYPICAL WIRE

C	Mn	Si
0.08	1.1	0.6

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Shielding gas	Condition	Yield strength (N/mm ²)	Tensile strength (N/mm ²)	Elongation (%)	Impact ISO-V(J) -40°C
Typical values	M21	AW	490	544	28	149

MATERIALS TO BE WELDED

Steel grades	Standard	Type
General structural steel	EN 10025	S185, S235, S275, S355
Ship plates	ASTM A131	Grade A, B, D, AH32 to DH 36.
Cast steel	EN 10213-2	GP240R
Pipe material	EN 10208-1	L210, L240, L290, L360
	EN 10208-2	L240NB, L290NB, L360NB, L360QB, L240MB, L290MB, L360MB, L415MB, L415NB
	API 5LX	X42, X46, X52, X60
	EN 10216-1	P235T1, P235T2, P275T1
	EN 10217-1	P275T2, P355N
Boiler & pressure vessel steel	EN 10028-2	P235GH, P265GH, P295GH, P355GH
Fine grained steel	EN 10025 part 3	S275, S355, S420
	EN 10025 part 4	S275M, S275ML, S355M, S355ML, S420M, S420ML

PACKAGING AND AVAILABLE SIZES

	Diameter (mm)	0.8	1.0	1.2
Unit :	15 kg spool B300	X	X	X
	250 kg Accutrak® Drum		X	X

Other sizes and packaging on request

LNM 25: rev. EN 25