

LNM28

Key Features

- Solid wire containing 1% Ni and Cu
- Stable arc and excellent feedability
- High impact values @ -40°C

Conformances

AWS A5.28/A5.28M: ER80S-G
AS/NZS 14341-A: G Z Mn3 Ni1 Cu* (closest)

Typical Applications

- Suitable for transport industry and general fabrication
- Ideal for weather resistant steels - i.e. COR-TEN
- Colour matching for weathering steels in prefabrication conditions (also see Conarc 55CT and Outershield 500CT)

Welding Positions



Shielding Gas

- M21 : 75-85% Argon / 15-25% CO₂
- Flow Rate: 15-20 L/min

Diameter / Packaging / Settings

Diameter mm	Part Number	Packaging	WFS ipm	Voltage volts	Current amps	CTWD mm
1.0	S10K016PCC01	Basket B300 ¹ 16kg	125-400	19-28	145-250	15-20
1.2	S12K016PCC01	Basket B300 ¹ 16kg	125-400	21-28	160-300	20-25
1.2	S12D250ECS01	250kg drum	125-400	21-28	160-300	20-25

1. B300 wire basket (2158341 adaptor required)

Mechanical Properties - As required per AWS A5.28

	Yield Strength MPa	Tensile Strength MPa	Elongation %	Charpy V-Notch J @ -40°C
Requirements - AWS ER80S-G	-	550 min	-	-
Typical Results	570	620	26	70

Wire Composition

	%C	%Mn	%Si	%Ni	%Cu
Typical Results	0.10	1.40	0.75	0.8	0.30