LNM 19

TOP FEATURES

- Also suitable where some resistance to hydrogen attack by sulphur bearing crude oil is required.
- Excellent mechanical characteristics.
- Can also be used to weld 0.9% Cr and 0.5% Mo steels.

TYPICAL APPLICATIONS

- Oil & Gas
- Thermal Power
- Pressure vessels
- Chemical
- Boilers, plates, tubes steels

CLASSIFICATION

AWS A5.28	ER80S-G*
EN ISO 21952-A	G CrMo1Si

* Nearest classification ER80S-B2

SHIELDING GASES (ACC. EN ISO 14175)

M21	Mixed gas Ar+ 15-25% CO_2
C1	Active gas 100% CO_2
M13	Mixed gas Ar+ 0.5-3% O_2

APPROVALS

TÜV	CE
+	+

CHEMICAL COMPOSITION (WEIGHT %), TYPICAL, WIRE

C	Mn	Si	Cr	Mo
0.1	1.0	0.5	1.2	0.5

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Shielding gas	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J) +20°C
Typical values	M21	PWHT 700°C/1h	530	635	23	160

* PWHT = Post Weld Heat Treatment

PACKAGING AND AVAILABLE SIZES

Wire diameter (mm)	Packaging	Weight (kg)	Item number
1.0	SPOOL (B300)	15.0	581089
1.2	SPOOL (B300)	15.0	581065

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: