

# LNM Ni1

**TOP FEATURES**

- Ideal for low temperature applications.
- The weld metal contains less than 1% Ni, conforming to NACE requirements.
- Stable arc and excellent feedability.

**TYPICAL APPLICATIONS**

- LNG
- Cryogenic Applications
- Pipelaying

**CLASSIFICATION**

AWS A5.28	ER80S-Ni1
EN ISO 14341-A	G 46 5 M21 3Ni1

**SHIELDING GASES (ACC. EN ISO 14175)**

M21	Mixed gas Ar+ 15-25% CO <sub>2</sub>
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**APPROVALS**

TÜV	DB	CE
+	+	+

**CHEMICAL COMPOSITION (WEIGHT %), TYPICAL, WIRE**

C	Mn	Si	Ni
0.09	1.2	0.6	0.9

**MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL**

	Shielding gas	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J)
Typical values	M21	AW	480	580	30	-60 °C 60 -20 °C

\* AW = As welded

**PACKAGING AND AVAILABLE SIZES**

Wire diameter (mm)	Packaging	Weight (kg)	Item number
1.0	SPOOL (BS300)	15.0	582468
1.2	SPOOL (BS300)	15.0	582482

**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](http://www.lincolnelectric.eu) for any updated information.