

# LNT 19

## CLASSIFICATION

AWS A5.28 - ER80S-B2\*  
ISO 21952-A - W CrMo1Si

\* Nearest classification

## GENERAL DESCRIPTION

**Solid rod for welding creep and hydrogen resistant Cr-Mo steels (1,25Cr - 0,5Mo)**  
**Service temperature up to 550°C**

## SHIELDING GASES (ACC. ISO 14175)

I1 Inert gas Ar (100%)

## APPROVALS

TÜV

+

## CHEMICAL COMPOSITION (W%) TYPICAL WIRE

C	Mn	Si	Cr	Mo
0.1	1.0	0.6	1.2	0.5

## MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Shielding gas	Condition	Yield strength (N/mm <sup>2</sup> )	Tensile strength (N/mm <sup>2</sup> )	Elongation (%)	Impact ISO-V(J) -10°C
Typical values	I1	AW	442	545	28	177

## MATERIALS TO BE WELDED

Steel grades	Standard	Type
Elevated temperature steel	EN 10028-2	13 CrMo4-5
	EN 10083-1	25 CrMo 4
	EN 10222-2	14 CrMo 4-5
Tool steel	DIN 17210	16 MnCr 5

## PACKAGING AND AVAILABLE SIZES

Diameter (mm)	1.6	2.0	2.4	3.0
Unit : 2 & 5 kg tube	X	X	X	X

Note : Cut length = 1000 mm

Other sizes and packaging on request

LNT 19: rev. EN 23