

LNM MoNiVa

CLASSIFICATION

AWS A5.28	ER110S-G	A-Nr	12
EN ISO 16834-A	G 69 4 M Mn3NiCrM	F-Nr	6
		9606 FM	2

GENERAL DESCRIPTION

Solid wire for welding high strength steels with yield strength up to 690 N/mm²
Good impact values at -40°C

WELDING POSITIONS (ISO/ASME)



PA/1G



PB/2F



PC/2G



PD/4F



PE/4G



PF/3Gu

SHIELDING GASES (ACC. ISO 14175)

M21 Mixed gas Ar+ >15-25% CO₂

APPROVALS

ABS	DB	TÜV	CE
+	+	+	+

CHEMICAL COMPOSITION (W%) TYPICAL WIRE

C	Mn	Si	Ni	Cr	Mo	V	Cu
0.08	1.7	0.44	1.35	0.23	0.3	0.08	0.25

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

Typical values	Shielding gas	Condition	Yield strength	Tensile strength	Elongation	Impact ISO-V(J)
			(N/mm ²)	(N/mm ²)	(%)	-40°C
	M21	AW	710	790	20	70

EXAMPLES OF MATERIALS TO BE WELDED

Steel grades	Standard	Type
Pipe material	API-5LX	X65, X70, X80
	EN 10208-2	L480, L550
Fine grained steels	EN 10025 part 6	S460, S500, S550, S620 S690
		S620GI1, S600MC, TstE620, Weldox 500, Hardox

PACKAGING AND AVAILABLE SIZES

Diameter (mm)	0.8	1.0	1.2
16 kg spool B300	X	X	X

Other sizes and packaging on request

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