

LNT/LNM NiCro 31/27

Ni-base solid wire

Classification

AWS A5.9 : ER383
EN 12072 : W 27 31 4 Cu L / G 27 31 4 Cu L

General description

Solid wire for welding of Cu-alloyed NiCrMo-steels

Excellent resistance to general corrosion, pitting and stress corrosion in acid and alkaline environments

Especially for applications in phosphoric and sulphuric acid

Shielding gases (acc. EN 439)

GTAW / GMAW I1 Inert gas Ar (100%)
I3 Inert gas Ar+ >0-95% He

Chemical composition (w%). typical wire / rod

C	Mn	Si	Ni	Cr	Mo	Cu
0.01	1.5	0.2	31.0	27.0	3.5	1.0

Mechanical properties, typical, all weld metal

	Process	Shielding gas	Condition	Yield strength (N/mm ²)	Tensile strength (N/mm ²)	Elongation (%)	Impact ISO-V(J) +20°C -196°C	
Typical values	GTAW	I1	AW	400	610	35	100	50
	GMAW	I1	AW	400	610	35	100	50

Materials to be welded

Material type	EN 10088-1/2	W.Nr.	ASTM/ACI	UNS
Copper alloyed CrNiMo- and NiCrMo-steels	X1NiCrMoCu 31-27-4	1.4563		N08028
	X1NiCrMoCu 25-20-5	1.4539	Alloy 904L	N08904
	DIN 17744			
	NiCr 21 Mo	2.4858	Alloy 825	N08825
	NiCr 21 Mo 6Cu	2.6410	Alloy 825 h Mo	N08821
	X3NiCrMoTi 27-23	1.4503		

Packaging and available sizes

Process	Unit	Diameter (mm)	1.2	2.0	2.4
GTAW	2 kg tube			X	X
GMAW	15 kg spool B300		X		

Other sizes and packaging on request

LNT/LNM NiCro 31/27: rev. EN 20