# FILLER MATERIAL FOR GTA AND GMA WELDING

## LOW ALLOYED STEEL

| Product name | Chemical composition (typical values) in % | | | | | | | Classifications | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | C | Mn | Si | Cr | Mo | Ni | others | AWS | | EN GTAW | | EN GMAW | |
| LNT/LNM 28 | 0.1 | 1.4 | 0.75 | - | - | 0.8 | Cu=0.3 | A5.28 | ER80S-G | | | | |
| LNM MoNiVa | 0.08 | 1.7 | 0.44 | 0.23 | 0.3 | 1.35 | V=0.08<br>Cu=0.25 | A5.28 | ER100S-G | | | EN 12534 | G 69 4 M Mn3Ni1CrMo |
| LNT/LNM Ni 1 | 0.09 | 1.2 | 0.6 | - | - | 0.9 | | A5.28 | ER80S-Ni1 | EN 1668 | W 42 6 W3Ni1 | EN 440 | G 46 5 M G3Ni1 |
| LNT/LNM Ni 2.5 | 0.1 | 1.2 | 0.5 | - | - | 2.5 | | A5.28 | ER80S-Ni2 | EN 1668 | W 46 6 W2Ni2 | EN 440 | G 46 6 M G2Ni2 |
| LNT/LNM 12 | 0.12 | 1.2 | 0.6 | - | 0.5 | - | | A5.28 | ER70S-A1 | EN 12070 | W MoSi | EN 440 | G 46 3 M G2Mo |
| LNT/LNM 19 | 0.1 | 1.0 | 0.5 | 1.2 | 0.5 | - | | A5.28 | ER80S-B2* | EN 12070 | W CrMo1Si | EN 12070 | G CrMo1Si |
| LNT/LNM 20 | 0.09 | 1.0 | 0.6 | 2.5 | 0.9 | - | | A5.28 | ER90S-B3* | EN 12070 | W CrMo2Si | EN 12070 | G CrMo2Si |
| LNT 502 | 0.08 | 0.5 | 0.5 | 5.8 | 0.6 | - | | A5.28 | ER80S-B6 | EN 12070 | W CrMo5Si | | |
| LNT9Cr (P91) | 0.07 | 0.7 | 0.4 | 8.7 | 0.9 | 0.7 | N=0.05<br>V=0.2<br>Nb=0.04 | A5.28 | ER90S-B9* | EN 12070 | W CrMo91 | | |

* nearest classification