

LNT/LNM Zeron 100X

Stainless solid wire

Classification

EN 12072-99 : W 25 9 4 N L / G 25 9 4 N L

General description

Solid wire for welding Zeron 100® and other super duplex stainless steel grades
High resistance to pitting and crevice corrosion in seawater

Shielding gases (acc. EN 439)

GTAW	I1	Inert gas Ar (100%)
GMAW	M12	Mixed gas Ar+ >0-5% CO ₂
GMAW	M13	Mixed gas Ar+ >0-3% O ₂

Approvals

	TÜV
GTAW	+

Chemical composition (w%), typical, wire / rod

C	Mn	Si	Cr	Ni	Mo	Cu	W	N
0.015	0.7	0.4	25.0	9.8	3.7	0.6	0.7	0.22

Mechanical properties, typical, all weld metal

	Process	Shielding gas	Condition	0.2% Proof strength	Tensile strength	Elongation	Impact ISO-V(J)	
				(N/mm ²)	(N/mm ²)	(%)	-20°C	-46°C
Typical values	GTAW	I1	AW	680	885	26	80	60
	GMAW	M12	AW	655	845	23	75	55

Materials to be welded

	EN 10088-1/-2	E 102 13-4	W.Nr.	ASTM/ACI A276/A351/A473	UNS
Regular duplex stainless steel grades	X4 CrNiMoN 27-5-2		1.4460		
	X2 CrNiMoN 22-5-3		1.4462	2205	S31803
		GX6 CrNiMo 24-8-2	1.4463		
				CD-4MCu Zeron 100	S32550 S32760

Super duplex stainless steel grades: chemical composition approximately:
 24-27% Cr, 6-9% Ni, 3-4% Mo, 0.10-0.25% N alloyed also with Cu and/or W (Zeron 100™)

Packaging

Process	Unit	Sizes (mm)				
		1.0	1.2	1.6	2.4	3.2
GTAW	2 kg tube			X	X	X
GMAW	12.5 kg spool B300	X	X	X		

Other sizes and packaging on request

LNT/LNM Zeron 100X: rev. EN 15