

# Keuze lastoevoegmateriaal voor ongelijksoortige verbindingen

| Legering         | Materiaal No. | 316L   | 904L / 28  | 254 / 925  | 310S   | 815  | CMn staal   |
|------------------|---------------|--|--|--|--|--|---|
|                  |               | 1.4404   | 1.4539 / 63  | 1.4547 / 29  | 1.4845 / 41  | 1.4893   |   |
| 1¼Cr + ½Mo       | 1.7335        | NiCro 70/15Mn<br>NiCro 70/19<br>LNT NiCro 70/19<br>LNM NiCro 70/19 |  |  | NiCro 70/15Mn<br>NiCro 70/19<br>LNT NiCro 70/19<br>LNM NiCro 70/19 | NiCro 70/15Mn<br>NiCro 70/19<br>LNT NiCro 70/19<br>LNM NiCro 70/19 | SL 19G<br>SL 20G                                      |
| 2¼Cr + ½Mo       | 1.7380        |  |  |  |  |  |   |
| 316L             | 1.4404        | Arosta 316L<br>LNT 316LSi<br>LNM 316LSi                            | Jungo 4500<br>LNT 4500 <sup>++</sup><br>LNM 4500 <sup>++</sup> | NiCro 60/20<br>LNT NiCro 60/20<br>LNM NiCro 60/20                  | Arosta 309S<br>LNT 309LSi<br>LNM 309LSi                            | Arosta 309S<br>LNT 309LSi<br>LNM 309LSi                            | Arosta 309S<br>LNT 309LSi<br>LNM 309LSi               |
| 904L(N)          | 1.4539        |  | Jungo 4500<br>LNT 4500 <sup>++</sup><br>LNM 4500 <sup>++</sup> | NiCro 60/20*<br>LNT NiCro 60/20<br>LNM NiCro 60/20                 | Jungo 4500<br>LNT 4500 <sup>++</sup><br>LNM 4500 <sup>++</sup>     | Jungo 4500<br>LNT 4500 <sup>++</sup><br>LNM 4500 <sup>++</sup>     | Arosta 309S <sup>++</sup><br>LNT 309LSi<br>LNM 309LSi |
| 28 <sup>++</sup> | 1.4563        |  |  |  |  |  |   |
| 254              | 1.4547        |  |  | NiCro 70/15Mn<br>NiCro 70/19<br>LNT NiCro 70/19<br>LNM NiCro 70/19 | NiCro 60/20<br>LNT NiCro 60/20<br>LNM NiCro 60/20                  | NiCro 60/20<br>LNT NiCro 60/20<br>LNM NiCro 60/20                  | NiCro 60/20<br>LNT NiCro 60/20<br>LNM NiCro 60/20     |
| 925/926          | 1.4529        |  |  |  |  |  |   |
| 310S             | 1.4845        |  |  |  | Intherma 310<br>LNT 310<br>LNM 310                                 | Intherma 310<br>LNT 310<br>LNM 310                                 | Arosta 309S<br>LNT 309LSi<br>LNM 309LSi               |
| (CrNi25-20)      | 1.4841        |  |  |  |  |  |   |
| 815<br>(253 MA)  | 1.4893        |  |  |  |  | NiCro 70/19<br>LNT NiCro 70/19<br>LNM NiCro 70/19                  | Arosta 309S<br>LNT 309LSi<br>LNM 309LSi               |

\* of een Nb vrij product:  
NiCroMo 66/22  
LNT NiCroMo 66/22  
LNM NiCroMo 66/22  
++ Voor legering 28 gebruik de NiCro 31/27