

LNG I

CLASSIFICATION

AWS 5.2	R45*	A-Nr	1	Mat-Nr	1.0324
EN 12536	01	F-Nr	6		
	* Nearest classification	Mat-Nr	-		

GENERAL DESCRIPTION

Rods for oxy-acetylene gas welding of general construction steel

Suitable for mild steel

Max. design temperature 350°C

CHEMICAL COMPOSITION (W%) TYPICAL WIRES

C	Mn	Si	P	S	Cr	Ni	Mo
0.07	0.5	0.1	0.01	0.01	0.04	0.03	0.01

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Condition	Yield strength (N/mm ²)	Tensile strength (N/mm ²)	Elongation (%)	Impact ISO-V(J) +20°C
Typical values	AW	280	390	16	50

EXAMPLES OF MATERIALS TO BE WELDED

Steel grades	Type
Pipe material	L210 up to L290
General structural steels	S185 up to S275

PACKAGING AND AVAILABLE SIZES

Diameter (mm)	2.0	3.0
5 kg cardboard box	X	X

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