

LNG II

CLASSIFICATION

AWS 5.2	R60*	A-Nr	1	Mat-Nr	1.0349
EN 12536	O II	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
 Higher strength than LNG I

CHEMICAL COMPOSITION (W%) TYPICAL WIRES

C	Mn	Si	P	S
0.10	1.1	0.15	0.01	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	320	430	17	60

EXAMPLES OF MATERIALS TO BE WELDED

Steel grades	Type
Pipe material	L210 up to L290
General structural steels	Si85 up to S275

PACKAGING AND AVAILABLE SIZES

Diameter (mm)	1.6	2.0	2.5	3.0	4.0
5 kg cardboard box	X	X	X	X	X

LNG II: rev. C-EN23-01/02/16

All information in this data sheet is accurate to the best of our knowledge at the time of printing. Please refer to www.lincolnelectric.eu for any updated information. Fumes: Material Safety Data Sheets (MSDS) are available on our website.