

LNG III

CLASSIFICATION

AWS A5.2 - R60 * Nearest classification
 EN 12536 - O III

GENERAL DESCRIPTION

Rods with 0.4% Ni for oxy-acetylene gas welding of joints in pipes
 Excellent rootwelding
 Applicable for design temperatures from -20°C to +350°C

APPROVALS

TÜV

+

CHEMICAL COMPOSITION (W%) TYPICAL WIRES

C	Mn	Si	P	S	Ni
0.06	1.1	0.15	0.01	0.01	0.40

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	340	470	26	65

MATERIALS TO BE WELDED

Steel grades	Standard	Type
Pipe material	EN 10208-2 API 5LX	L210 up to L290 X42 up to X46
General structural steel		S185 up to S275

PACKAGING AND AVAILABLE SIZES

Diameter (mm)	2.0	2.5	3.0	4.0	5.0
Unit : 5 kg carton box	X	X	X	X	X
25 kg carton box	X	X	X	X	X
Other sizes and packaging on request					

LNG III: rev. EN 23