

# LNT 24

## CLASSIFICATION

AWS A5.18 ER70S-2

## GENERAL DESCRIPTION

Mild Steel Tig Rod recommended for most grades of steel

Contains zirconium, titanium, and aluminum in addition to silicon and manganese

Recommended for root pass welding of steels up to 460 MPA YS

## SHIELDING GASES (ACC. ISO 14175)

I1 Inert gas Ar (100%)

## CHEMICAL COMPOSITION (W%) TYPICAL WIRE

C	Mn	Si	Ti	Zr	Al
0.05	1.20	0.5	0.10	0.05	0.08

## MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Shielding gas	Yield strength [N/mm <sup>2</sup> ]	Tensile strength [N/mm <sup>2</sup> ]	Elongation [%]	Impact ISO-V(J)	
					-20°C	-30°C
Typical values	I1	550	620	23	≥ 47J	≥ 27J

## EXAMPLES OF MATERIALS TO BE WELDED

### Type

S185-E360

S235JR-S355JR

S235JO-S450JO

S235J2-S355J2

S275N-S460N

S275M-S460M

S460Q

P235GH-P355GH

P275N-P460N

P355M-P460M

P355Q-P460Q

ASTM: A36, A106 grades A/B/C

API: 5L grades X42-X60

## PACKAGING AND AVAILABLE SIZES

Diameter (mm)	1.6	2.4	3.2	<i>Note : Cut length = 1000 mm</i>
5 kg PE-Tube	X	X	X	

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