

# LNT 25

## CLASSIFICATION

AWS A5.18/A5.18M : ER70S-3  
EN ISO 636-A : W 42 5 W2Si

## GENERAL DESCRIPTION

**Solid rod for welding general construction in mild steel**  
**High impact values**

## SHIELDING GASES (ACC. ISO 14175)

11 Inert gas Ar (100%)

## APPROVALS

TÜV CE

+ +

## CHEMICAL COMPOSITION (W%) TYPICAL WIRE

C	Mn	Si
0.08	1.1	0.6

## MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Shielding gas	Condition	Yield strength (N/mm <sup>2</sup> )	Tensile strength (N/mm <sup>2</sup> )	Elongation (%)	Impact ISO-V(J)	
						-20°C	-50°C
Typical values	11	AW	450	560	26	170	100

## MATERIALS TO BE WELDED

Steel grades	Standard	Type
<b>General structural steel</b>	EN 10025	S185, S235, S275, S355
<b>Ship plates</b>	ASTM A131	Grade A, B, D, AH32 to DH 36.
<b>Cast steel</b>	EN 10213-2	GP240R
<b>Pipe material</b>	EN 10208-1	L210, L240, L290, L360
	EN 10208-2	L240NB, L290NB, L360NB, L360QB, L240MB, L290MB, L360MB, L415MB, L415NB
	API 5LX	X42, X46, X52, X60
	EN 10216-1	P235T1, P235T2, P275T1
	EN 10217-1	P275T2, P355N
<b>Boiler &amp; pressure vessel steel</b>	EN 10028-2	P235GH, P265GH, P295GH, P355GH
<b>Fine grained steel</b>	EN 10025 part 3	S275, S355, S420
	EN 10025 part 4	S275M, S275ML, S355M, S355ML, S420M, S420ML

## PACKAGING AND AVAILABLE SIZES

Diameter (mm)	1.6	2.0	2.4	3.0
Unit : 2 and 5 kg tube	X	X	X	X

Other sizes and packaging on request

Note : Cut length = 1000 mm

LNT 25: rev. EN 24