

LNT 28

CLASSIFICATION

AWS A5.28 : ER80S-G

GENERAL DESCRIPTION

Solid rod for welding of weather resisting steels
Excellent mechanical properties

SHIELDING GASES (ACC. ISO 14175)

I1 Inert gas Ar (100%)

APPROVALS

CE

+

CHEMICAL COMPOSITION (W%) TYPICAL WIRE

C	Mn	Si	Ni	Cu
0.1	1.4	0.75	0.8	0.3

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Shielding gas	Condition	Yield strength (N/mm ²)	Tensile strength (N/mm ²)	Elongation (%)	Impact ISO-V(J) -20°C
Typical values	I1	AW	570	620	26	80

MATERIALS TO BE WELDED

Steel grades	Standard	Type
Weather resisting steels	EN 10155	S 235 J 0 W
		S 235 J 2 W
		S 355 J 0 W
		S 355 J 2 W
		S 355 K 2 G 1 W

PACKAGING AND AVAILABLE SIZES

Diameter (mm)	2.4	3.0
Unit : 5 kg tube	X	X

Note : Cut length = 1000 mm

Other sizes and packaging on request

LNT 28: rev. EN 22