

## Mild steel solid rod

### Classification

AWS A5.18/A5.18M : ER70S-3  
EN 1668 : W 42 5 W2Si

### General description

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

### Shielding gases (acc. ISO 14175)

I1 Inert gas Ar (100%)

### Approvals

TÜV

+

### Chemical composition (w%) typical wire / rod

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	I1	AW	450	560	26	170	100
		SR 15h/620°C	410	525	26		80

### Materials to be welded

Steel grades	Code	Type
<b>General structural steel</b>	EN 10025	S185, S235, S275, S355
<b>Ship plates</b>	ASTM A131	Grade A, B, D, AH32 to DH36
<b>Cast steel</b>	EN10213-2	GP240R
<b>Pipe material</b>	EN 10208-1	L210, L240, L290, L360
	EN 10208-2	L240NB, L290NB, L360NB, L360QB, L240MB, L290MB, L360MB, L451MB, L415NB
	API 5LX	X42, X46, X52, X60
	EN 10216-1/ EN 10217-1	P235T1, P235T2, P275T1 P275T2, P355N
<b>Boiler &amp; pressure vessel steel</b>	EN 10028-2	P235GH, P265GH, P295GH, P355GH
<b>Fine grained steel</b>	EN 10113-2	S275, S275, S355, S420
	EN 10113-3	S275M, S275ML, S355M, S355ML, S420M, S420ML

### Packaging and available sizes

Unit type	Diameter (mm)			
	1.6	2.0	2.4	3.0
2 and 5 kg tube	X	X	X	X
Other sizes and packaging on request				

LNT 25: rev. EN 22

**Liability:** All information in this data sheet is based on the best available knowledge, is subject to change without notice and can only be considered as suitable for general guidance **Fumes:** Consult information on Welding Safety Sheet, available upon request