

## CLASSIFICATION

EN ISO 14171 : S2 Mo (L-223 ile S 46 4 AB S2Mo)  
AWS A5.23 : EA2

## GENERAL DESCRIPTION

LSW-EA2 is copper coated submerged arc welding wire designed particularly for the welding of high impact resistant steels.

## CHEMICAL COMPOSITION (W%) TYPICAL, WIRE

C	Si	Mn	Mo
0.10	0.10	1.00	0.50
0.06*	0.25*	1.30*	0.50*

(\* Typical weld metal composition with flux LW 223

## APPROVALS (WITH FLUX LW-761)

GOST, SEPRO, TSE, TÜV

## MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

Yield Strength : 460 - 600 N/mm<sup>2</sup>  
Tensile Strength : 550 - 670 N/mm<sup>2</sup>  
Impact (ISO-V) : 50 J ( - 20°C)

**with flux LincolnWeld 223 :** Yield Strength : 470 N/mm<sup>2</sup>  
Tensile Strength : 550 N/mm<sup>2</sup>  
Elongation (L=5d) : 29%  
Impact (ISO-V) : 55 J ( - 20°C)

**Note :** Tensile and Yield Strength values are given in a wide range, as the submerged arc welding flux compositions might vary considerably.

## MATERIALS TO BE WELDED

	<b>DIN</b>	<b>EN</b>
<b>General Structural Steels</b>	St 33, St 34, St 37, St 44, St 44-2, St 44-3, St 52, St 52-3	S185, S235, S275, S355
<b>Fine Grained Steels</b>	StE 255 - StE 460 WStE 255 - WStE 460	S255N - S460N P255NH - P460NH
<b>Pipe Materials</b>	StE 320-7 - StE 415-7 StE 290-7 TM - StE 480-7 TM X42, X46, X52, X56, X60, X65, X70, X80 (API 5LX)	L320 - L415NB L290MB - L485MB -
<b>Boiler and Pressure Vessel Steels</b>	17 Mn 4, 19 Mn 5, 15 Mo 3 HI, HII, HIII	P295GH, P310GH, 16 Mo 3 P235GH, P265GH, P285NH
<b>Elevated Temperature Steels</b>	St 35-8, St 45-8	P235G1TH - P255G1TH

## PACKING AND DIAMETER INFORMATIONS

Diameter	2.0	2.4	3.2	4.0	Spool Weight	Drum Weight
<b>Submerged Arc Welding Wire</b>	-	-	X	X	25 kg	350 / 650 kg

**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.

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