

CLASSIFICATION

S EN ISO 636-A : W 42 3 W3Si1
AWS A5.18: ER70S-6

GENERAL DESCRIPTION

LT-56 is suitable for GTA welding of un-alloyed structural steels with a tensile strength up to 540 N/mm², ship plates and fine-grained C-Mn steels. It gives high-strength weld metal at working temperatures varying between -50 to 450°C.

CHEMICAL COMPOSITION (W%) TYPICAL, WIRE

C	Si	Mn
0.07	0.82	1.52

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

Yield Strength	: 440 N/mm ²
Tensile Strength	: 540 N/mm ²
Elongation (L=5d)	: 30 %
Impact (ISO-V)	: 60 J (-30°C)

SHIELDING GASES (ISO 14175 / EN 439)

TIG : I1 - Ar (100%)
Current Type and Polarity : DC (-)

MATERIALS TO BE WELDED

	DIN	EN
General Structural Steels	St 33, St 34, St 37, St 44, St 44-2, St 44-3, St 52, St 52-3 St 37-4, St 44-4, St 52-4 St 50-2, St 60-2 C 10 - C 35 ; Ck 10 - Ck 35	S185, S235, S275, S355 P235TR2 - P355T2 E295, E335 C10 - C35
Fine Grained Steels	StE 255 - StE 420 WStE 255 - WStE 355	S255N - S420N P255NH - P355NH
Pipe Materials	StE 210-7 - StE 360-7 StE 290-7 TM - StE 360-7 TM X42, X46, X52, X60 (API 5LX)	L210 - L360NB L290MB - L360MB -
Boiler and Pressure Vessel Steels	17 Mn 4, 19 Mn 6 HI, HII	P295GH, P355GH P235GH, P265GH
Elevated Temperature Steels	St 35-8, St 45-8	P235G1TH - P255G1TH
Ship Plates	A, B, C, D, E AH32 - EH36	- -
Cast Steels	GS-38, GS-45, GS-52	GE200, GE240, GE260

PACKING AND DIAMETER INFORMATIONS

Diameter	0.8	1.0	1.2	1.6	2.0	2.4	3.2	Tube Weight
TIG ROD	-	-	-	X	X	X	X	5 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.

Lion International U.K (M.E.) Limited

Monomark House, 27 Old Gloucester Street, London WC1N 3XX, United Kingdom.
T: +44 20 74198760 F: +44 20 78319489 E: info@lionintweld.co.uk

Lion International Middle East FZC

P.O. Box 41654, W/H No. 1K-01/4, Hamriyah Free Zone, Sharjah, UAE.
T: +971 6 5260461 F: +971 6 5260561 E: info.me@lionintweld.co.uk