

CLASSIFICATION

ISO 14341-A : G 42 3 C G4Si1 / G 42 3 M G4Si1
AWS A5.18 : ER70S-6

GENERAL DESCRIPTION

LC-50 3 is a copper coated gas metal arc welding wire in 15 kg spools or 250 kg drums. It is particularly designed for semi-automatic and full-automatic GMAW applications. Working temperature can range between -50 to 450°C.

CO₂ or 80% Ar - 20% CO₂ are used for gas shielding.

APPROVALS

DB, GOST, NAKS, SEPRO, TSE, TÜV

Shielding gas : CO₂

BV GL

3Y 3YS

Shielding gas : Ar + CO₂

GL

3YS

MATERIALS TO BE WELDED

	DIN	EN
General Structural Steels	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, St 70-2 C 10 - C 35 ; Ck 10 - Ck 35	S275, S355 P235TR2 - P355T2 E295, E335, E360 C10 - C35
Fine Grained Steels	StE 255 - StE 460 WStE 255 - WStE 355	S255N - S460N P255NH - P355NH
Pipe Materials	StE 210-7 - StE 415-7 X42, X46, X52, X60 (API 5LX)	L210 - L415NB -
Boiler and Pressure Vessel Steels	17 Mn 4, 19 Mn 6 H1, H11	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	Spool Weight	Drum Weight
MIG/MAG Wire	X	X	X	X	-	-	-	15 kg	250 kg

CHEMICAL COMPOSITION (W%) TYPICAL, WIRE

C	Si	Mn
0.08	1.00	1.70
0.06*	0.60*	1.20*

(*) Typical weld metal composition (CO₂ gas shielding)

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)

MAG : M21 - Ar + 5-25% CO₂ / C1 - CO₂ (100%)

Current Type and Polarity : DC (+)

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