

Lastofil 11017 TM

Welding of weather-resistant steel (such as Corten)

CLASSIFICATION

EN ISO 17632-A : T 46 4 Z M M21 1 H5

AWS A5.36 : E 81T15-M21A4-W2-H4

GENERAL DESCRIPTION

Metal-filled welding wire suitable for welding weather-resistant structural steels such as Corten steel, offshore structures, fine-grained steels and pipelines.

The wire is alloyed with copper and nickel, creating a high resistance to atmospheric corrosion.

Can be welded in single layers and in multiple layers.

Very low hydrogen content (<4.0 ml / 100 g).

APPLICATIONS

Weather resistant steels: S235JRW - S355JRW, 9CrNiCuP3-2-4, A588 or A709 Gr 50W

Steel structures: S185 - S355, A106 Gr.B, A333 Gr.6

Boiler steel: P235GH - P355GH

Fine grain steels: S460QL

Pipelines: P235T1/T2 - P460NL1, L210 - L415MB

Offshore structures

General fabrication

Automatic and mechanized welding

CHEMICAL COMPOSITION (%) (Typical values, all weld metal)

C :	0.05	Mn :	1.20	Si :	0.70	S :	0.015	P :	0.015
Ni :	0.70	Cr :	0.50	Cu :	0.50				

MECHANICAL PROPERTIES (Typical values, all weld metal)

Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation 5d (%)	Impact Strength Charpy V notch (ISO-V)
≥ 470 MPa	550 - 680 MPa	≥ 22%	≥ 47 J (-40°C)

GENERAL INFORMATION

Welding positions All

Shielding gas Ar/CO₂, M21 (EN ISO 14175)

Packing 16 kg spool (in a cardboard box)

Polarity DC+

Diameter (mm) 1.2

Tips & tricks

The coppered seamless wire can be welded with standard driving wheels but for smaller types of driving wheels the serrated wheels for tubular wire can work better.

The information in this document is based on intensive tests and is accurate to the best of our knowledge. Do note that these values are only typical values for tests in accordance to prescribed standards. The suitability of the product should always be confirmed by qualification tests before use in any application. The information can be changed without previous notice.