PRODUCT SPECIFICATION

Lastifil 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/mm²	Tensile Strength N/mm²	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.