

# Lastifil 11017 TR

## Rutile flux cored wire with 1% Ni

### CLASSIFICATION

EN ISO 17632-A : T 50 6 1Ni P M 1 H5

AWS A5.29 : E 81T1-Ni1M-J H4

### GENERAL DESCRIPTION

Lastifil 10011TR is a seamless rutile cored wire for welding unalloyed and low alloyed steel, up to S460, with shielding gas.

Due to 1% Ni addition, the wire can be used for applications down to -60 °C.

Very good weldability and smooth aspect. Slag can be removed easily.

Extra low hydrogen content of the weld deposit (<5 ml/100 g).

Ideally suited to be used on ceramic backing.

### APPLICATIONS

Structural steel: S185, S235-S460

Boiler steel: P235GH, P265GH, P295H, P355GH

Hull steel: A, B, D, E and AH32-AH36

Fine grained steel: S255 up to S500

API steel: X42-X80

Ship building, vessel construction, mechanical engineering, pipe welding, offshore applications.

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

<b>C :</b>	0.05	<b>Mn :</b>	1.30	<b>Si :</b>	0.50	<b>P :</b>	0.015	<b>S :</b>	0.015
<b>Ni :</b>	0.80								

### MECHANICAL PROPERTIES (Typical values, all weld metal)

Yield Strength N/mm <sup>2</sup>	Tensile Strength N/mm <sup>2</sup>	Elongation 5d (%)	Impact Strength Charpy V notch (ISO-V)
≥ 500 MPa	560 - 720 MPa	≥ 18%	≥ 47 J (-60°C)

### GENERAL INFORMATION

**Welding positions** All

**Shielding gas** Ar/CO<sub>2</sub>, M21 (EN ISO 14175) or 100% CO<sub>2</sub>

**Packing** 16 kg spool (in a cardboard box)

**Polarity** DC+

**Diameter (mm)** 1.2 1.6

#### Tips & tricks

Gas flow: 12-18 l/min.

Use a stick out of 15 to 20 mm in function of the diameter.

Before welding a next layer, slag must be removed from the previous layer.