PRODUCT SPECIFICATION

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)

C:	0.05 Mn : 1.30	Si : 0.50	P:	0.015	S:	0.015
Ni : 0.80						

MECHANICAL PROPERTIES (Typical values, all weld metal)

Yield Strength	Tensile Strength	Elongation	Impact Strength
N/mm²	N/mm²	5d (%)	Charpy V notch (ISO-V)
≥ 500 MPa	560 - 720 MPa	≥ 18%	≥ 47 J (-60°C)

GENERAL INFORMATION

Welding positions	All			
Shielding gas	Ar/CO2, M21 (EN ISO 14175) or 100% CO2			
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.

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.