PRODUCT SPECIFICATION

Lastifil 1216

Welding creep resistant steel

CLASSIFICATION

EN ISO 21952-A : G CrMo1Si
AWS A5.28 : ER 80S-G

GENERAL DESCRIPTION

Chromium - molybdenum alloyed welding wire suitable for welding creep resistant steel.
Welding steamboilers and pipes with a working temperature up to 570 °C (1060 °F).
Also suitable for welding case hardenend steel and high strength steel, refacing workpieces that have to be nitrited.

APPLICATIONS

Welding of 13CrMo44, 15CrMo3, 13CrMoV42, ASTM A 193grB7, ASTM A333 GrP11 and P12, cast steel GS17CrMo55.
Repair of steel 25CrMo4 and 42CrMo4, when a post weld heat treatment is applied.

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

C : 0.07 - 0.12	**Mn :** 0.50 - 1.20	**Si :** 0.40 - 0.70	**Cr :** 1.10 - 1.50	**Mo :** 0.40 - 0.65

MECHANICAL PROPERTIES (Typical values, all weld metal)

Yield Strength N/mm²	Tensile Strength N/mm²	Elongation 5d (%)	Impact Strength Charpy V notch (ISO-V)
≥ 355 MPa	≥ 510 MPa	≥ 20%	≥ 47 J (-10°C)

GENERAL INFORMATION

Welding positions	All			
Shielding gas	Ar/CO2, M21 (EN ISO 14175) or 100% CO2			
Packing	15 kg spool (in a cardboard box)			
Polarity	DC+			
Diameter (mm)	0.8	1.0	1.2	1.6

Tips & tricks

Welding of 13CrMo44: heattreatment for basemetal shall be applied:
- Preheating 200-250 °C (390-480 °F)
- Post weld heat treatment 660-700 °C (1220-1290 °F) during minimum 1/2 hour.