

Lastofil 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 hardened steel and high strength steel, refacing workpieces that have to be nitrated.

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
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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)
≥ 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.

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.