PRODUCT SPECIFICATION

Lastifil 20 CM

Solid welding wire - MAG welding of mild steel

CLASSIFICATION

EN ISO 14341-A : G 46 4 M21 4Si1
AWS A5.18 : ER 70S-6

GENERAL DESCRIPTION

Welding wire for steel constructions with very high requirements for mechanical characteristics and weldability.
The perfect spooling, the uniform copper coating, the low torsion in the wire, the small tolerances on the diameter and the high degree of purity, guarantee an optimal and constant welding quality.
The mechanical characteristics are higher than those of most lime type electrodes.

APPLICATIONS

For boiler work, machine building, ship building, sheet metal welding etc…
Structural steel: St37 - St52, S235 - S355, St52-3, St50-2, St60-2 (**), P235 - P355
High strength fine-grained steel StE255 to StE420 and StE355, A242, A440, A441, A588.
Boilerplate HI, HIII, 17Mn4, 19Mn5, A414grA,B,C,D,E,F, A662grA,B.
Pipe steel St35.8, St45.8, St52.4, A53grA,B, A106grC, A714grI, II, III.
Hull steel A, B, D, E.
Cast steel GS-38, GS-45, GS-52, A27, A486gr70, A643grA, A732gr1A,2A,3A.
BS 4360 grades 40, 43 and 50.

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

C : 0.06 - 0.14	**Mn :** 1.60 - 1.90	**Si :** 0.80 - 1.20	**P :** < 0.025	**S :** < 0.025
Cu : < 0.35	**Fe :** Balance			

MECHANICAL PROPERTIES (Typical values, all weld metal)

Yield Strength N/mm²	Tensile Strength N/mm²	Elongation 5d (%)	Impact Strength Charpy V notch (ISO-V)
≥ 460 MPa	530 - 670 MPa	≥ 20%	≥ 47 J (-40°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)	1.0 1.2
Tips & tricks	Gas flow in short arc 8 to 10 liter/min (17-21 cu.ft./hr), in spray arc 12 to 17 liter/min (25-36 cu.ft./hr). When welding outdoors protect the welding area against wind and draught and increase the gas flow. The highest mechanical strength is obtained in short arc (Lower burn off of alloying elements.). Preheat steel 60 in function of the plate thickness.