PRODUCT SPECIFICATION

Lastifil 809 G

Cored wire for crack resistant joints

CLASSIFICATION

EN 12073 : T 23 12 2 L R C/M 3
AWS A5.22 : E 309L Mo T0-4

GENERAL DESCRIPTION

Used for joining stainless steel and difficult to weld steels and joining Cr/Ni/Mo steels with low carbon content (C<0.03%).
Very good corrosion resistance.
High strength and creep resistance at high temperatures.
High fluidity. Regular and beautifully formed beads.
Excellent X-ray quality.

APPLICATIONS

Joining stainless steel and difficult to weld steels, Cr-Mo steel, high carbon containing steel, Mo-containing steels.
Joining stainless steel to mild steel.

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

C :	< 0.04	**Mn :**	0.50 - 1.50	**Si :**	0.50 - 1.00	**Cr :**	23.00 - 25.00	**Ni :**	12.00 - 14.00
Mo :	2.00 - 3.00	**P :**	< 0.04	**S :**	< 0.03	**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)
	≥ 580 MPa	≥ 31%	

GENERAL INFORMATION

Welding positions	All
Shielding gas	Ar/CO2, M21 (EN ISO 14175) or 100% CO2
Packing	12.5 kg spool (in a cardboard box)
Polarity	DC+
Diameter (mm)	0.9 1.2

Tips & tricks

Remove all traces of dirt from the weld edges.
Weld with a ‘stick-out’ of 15 to 25 mm (0.6-1").
Before depositing a second layer, always remove the slag with a stainless steel brush or grinding disc.
The interpass-temperature in the welding zone has to remain below 200 °C (400 °F): if not, cool down before applying a new layer.
To get a correct wire feed, it is necessary to use the appropriate driving wheels for flux cored wires on the wire feeder.