

Lastek 10015

Welding low alloy high strength steels

CLASSIFICATION

EN ISO 18275-A : E 69 4 Mn2NiCrMo B 42

AWS A5.5 : E 10018-G

GENERAL DESCRIPTION

Low hydrogen electrode for welding quenched and tempered or micro alloyed steels.

The Charpy V impact strength is high, also at sub zero temperatures.

It has an excellent welder appeal thanks to the specific composition of the coating.

This coating is moisture resistant.

APPLICATIONS

Welding of T1 steel, HY80, NAXTRA65,70, Superelso, Superelso 700.

For boilers, tanks, dredging equipment, construction,- excavating-, mining equipment.

Welding of high strength rails.

Repair on forklifts.

Heavy machinery.

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

C : 0.03 - 0.10	Mn : 1.40 - 2.00	Si : < 0.60	Cr : 0.30 - 0.60	Ni : 1.80 - 2.60
Mo : 0.30 - 0.60	P : < 0.02	S : < 0.02		

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)
≥ 690 MPa	760 - 960 MPa	≥ 18%	≥ 47 J (-40°C)

GENERAL INFORMATION

Welding positions All

Shielding gas NA

Packing 5 kg in a plastic box

Polarity DC, reverse polarity (electrode positive) - for root pass use straight polarity

Diameter (mm) 2.5 3.2 4.0 5.0

Length (mm) 350 350 450 450

Tips & tricks

Clean weld area and weld with a short arc.

Use stringer beads and avoid weaving for the highest mechanical characteristics.

If required, dry the electrodes at 250-300 °C (480-570 °F) for 2 hours.

Open circuit voltage: 70 V

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.