

Lastek 171

Root pass in steel pipes

CLASSIFICATION

EN ISO 636-A : W 42 4 W 3Si1

AWS A5.18 : ER 70S-6

GENERAL DESCRIPTION

Copper coated welding rod for TIG-welding of mild steel.
Lastek 171 is recommended for root pass welding in pipes and plates.

APPLICATIONS

Recommended for welding following base materials:

Structural steel: St 34 - St52

Pipe steel: St 35.8 - St 45.8

Boiler steel: HI - HIV, 17Mn4, 19Mn5

Cast steel: GS38 - GS 45

Ship steel: A - B - C - D - E

Fine grained steel: St E255 - StE355 - StE380.

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

C : 0.06 - 0.14	Si : 0.70 - 1.00	Mn : 1.30 - 1.60	P : < 0.025	S : < 0.025
Fe : Balance				

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)
≥ 420 MPa	500 - 640 MPa	≥ 20%	≥ 47 J (-40°C)

GENERAL INFORMATION

Welding positions NA

Shielding gas Argon

Packing 5 kg in a cardboard box

Polarity DC, with the torch on the negative pole.

Diameter (mm)	1.2	1.6	2.0	2.4	3.0
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Length (mm)	1000	1000	1000	1000	1000
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Tips & tricks Gas flow min. 8 l/min

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.