PRODUCT SPECIFICATION

Lastifil 10015

Welding high tensile fine-grained structural steels

CLASSIFICATION

EN ISO 16834-A : G 69 4 M21 Mn3Ni1CrMo
AWS A5.28 : ER 110S-G

GENERAL DESCRIPTION

Welding wire for joining low alloy steel, fine-grained and TMCP steel with a high yield point.
High impact strength also at temperatures subzero.

APPLICATIONS

Welding of steels like T1 steel, T1-A and T1-B, HOAG N-A-XTRA56, 63, 65, 70, Superelso 700, HY80, HY100, Dillimax 690, Weldox 700, etc.
Parts and chassis of earth moving machines, dredging equipment, mining equipment, etc.
Welding of rails.
Welding of case-hardening steel and high tensile steel.
Repair on forklifts and heavy duty machinery.

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

C :	0.07 - 0.12	**Mn :**	1.30 - 1.80	**Si :**	0.40 - 0.70	**Cr :**	0.20 - 0.40	**Mo :**	0.20 - 0.30
Ni :	1.40 - 1.60	**V :**	0.05 - 0.13	**P :**	< 0.015	**S :**	< 0.015	**Al :**	< 0.10

MECHANICAL PROPERTIES (Typical values, all weld metal)

Yield Strength N/mm²	Tensile Strength N/mm²	Elongation 5d (%)	Impact Strength Charpy V notch (ISO-V)
≥ 690 MPa	770 - 940 MPa	≥ 17%	≥ 180 J (R.T.) / ≥ 70 J (-50°C)

GENERAL INFORMATION

Welding positions	All, except vertical down.			
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

Remove grease and impurities of the base metal.
When welding outdoors, use windscreens and increase the gas flow.