

# Lastifil 10015 TM

## Metal powder cored wire with high tensile strength

### CLASSIFICATION

EN ISO 18276-A : T 69 6 Mn2NiCrMo M M 1 H5

AWS A5.28 : E 110C-K4 H4

### GENERAL DESCRIPTION

Lastifil 10015 TM is a seamless copper coated cored wire for welding low alloy high strength steel.

The absence of slag permits multilayer welding without time consuming slag removal.

Excellent weldability in short arc and spray mode.

High efficiency.

### APPLICATIONS

High strength steel applications in bridges, cranes, vessels, excavating and roadbuilding equipment.

StE 690V, XAB0620, Weldox 700, N-AXTRA 63 and N-AXTRA 70, StE 690.7TM, 1.8931, 1.8914, 1.8964, 1.8979, 1.6779, 1.6781.

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

<b>C :</b>	0.05	<b>Mn :</b>	1.60	<b>Si :</b>	0.40	<b>P &amp; S :</b>	0.015	<b>Cr :</b>	0.50
<b>Ni :</b>	2.20	<b>Mo :</b>	0.50						

### MECHANICAL PROPERTIES (Typical values, all weld metal)

Yield Strength N/mm <sup>2</sup>	Tensile Strength N/mm <sup>2</sup>	Elongation 5d (%)	Impact Strength Charpy V notch (ISO-V)
≥ 690 MPa	770 - 940 MPa	≥ 17%	≥ 47 J (-60°C)

### GENERAL INFORMATION

**Welding positions** All

**Shielding gas** Ar/CO<sub>2</sub>, M21 (EN ISO 14175)

**Packing** 16 kg spool (in a cardboard box)

**Polarity** DC+

**Diameter (mm)** 1.2      1.4      1.6

**Tips & tricks** Remove grease and impurities of the weld area.

*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.*