

# Lastifil 20 TB

## Basic flux cored wire

### CLASSIFICATION

EN ISO 17632-A : T 46 6 B M 3 H5

AWS A5.20 : E 70T-5M-J H4

### GENERAL DESCRIPTION

Lastifil 20TB is low hydrogen flux cored copper coated seamless wire for welding mild and low alloyed steels.

The basic flux in the core guarantees good low temperature impact properties.

Lastifil 20 TB gives no spatters and has an excellent slag release.

The wire is copper coated for better feeding characteristics and is hermetically closed so that moisture pick up is avoided.

### APPLICATIONS

Welding load-bearing and dynamically loaded structures.

Welding structural steel (S235 to S355) and low alloy steel with tensile strength up to 600 N/mm<sup>2</sup>.

Structural steel: S185, S235 - S355 (EN 10025).

Boiler plate: P235GH, P265GH, P295GH (EN 10028-2).

Pipe steel: P235T1 - P355N (EN 10217-1); P235T2 - P355N (EN 10217-3); StE290.7TM - StE480.7TM (EN 10208-2).

API steel: X42 - X70.

Fine grain steel: StE355 - StE460 (EN 10028-3).

Hull steel grade A, B, D, E, AH32 - EH36.

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

<b>C :</b> 0.05	<b>Mn :</b> 1.40	<b>Si :</b> 0.60	<b>P :</b> 0.015	<b>S :</b> 0.015
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### 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)
≥ 460 MPa	530 - 680 MPa	≥ 20%	≥ 47 J (-60°C)

### GENERAL INFORMATION

**Welding positions** PA, PB, PC, PF

**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 1.6

#### Tips & tricks

Shielding gas: 10-15 l/min.

Use a stick out of 20 to 25 mm (0.8-1 inch) in function of the diameter.

Before welding the next layer, the thin almost self-releasing slag from the previous layer must be removed.