

Lastofil 804 G

Cored wire for stainless steel 316L

CLASSIFICATION

AWS A5.22 : E 316LT0-1/4

GENERAL DESCRIPTION

Cored wire for welding low carbon (C < 0.03 %) stainless steel of type 18/8/Mo.
High resistance against intergranular corrosion.
Regular and beautifully formed beads.
Excellent X-ray quality.

APPLICATIONS

Stainless steel with CrNiMo: AISI 316L – 316 (1.4401 – 1.4571 – 1.4580 – 1.4408 – 1.4435 – 1.4436 – 1.4573 – 1.4581 – 1.4583).
Cast steel: ASTM CF3M - CF8M - CF12M.

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

C : < 0.04	Ni : 11.00 - 14.00	Cr : 17.00 - 20.00	Mo : 2.00 - 3.00	Si : < 1.00
Mn : 0.50 - 2.50	P : < 0.04	S : < 0.04		

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)
≥ 310 MPa	≥ 485 MPa	≥ 25%	

GENERAL INFORMATION

Welding positions	All		
Shielding gas	Ar/CO ₂ , M21 (EN ISO 14175) or 100% CO ₂		
Packing	12.5 kg spool (in a cardboard box)		
Polarity	DC+		
Diameter (mm)	0.9	1.2	1.6
Approx. current (A)	95	175	225

Tips & tricks

- Remove all traces of dirt from the weld edges.
- Weld with a 'stick-out' of 15 to 25 mm (0.6-1").
- Before depositing a second layer, always remove the slag with a stainless steel brush or grinding disc.
- The interpass-temperature in the welding zone has to remain below 200 °C (400 °F): if not, cool down before applying a new layer.
- To get a correct wire feed, it is necessary to use the appropriate driving wheels for flux cored wires on the wire feeder.

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.