

Lastek 1216 C

Mild and creep resistant steel

CLASSIFICATION

EN ISO 21952-A : W CrMo1Si

AWS A5.28 : ER 80S-G

GENERAL DESCRIPTION

Welding rod for gas tungsten arc welding (TIG) of mild steels, low-alloy steel and creep resistant steels.

Heat resistant up to 550 °C.

Porous free and excellent X-ray quality.

Can be used for joining case hardening and hardenable steels as AISI 4130 -

DIN 25CrMo4 - 42CrMo4 with an appropriate preheat.

Can be nitrided.

APPLICATIONS

Piping, tanks and apparatus construction.

X-ray welding.

Suitable for welding the next materials:

boiler plate HIV, 13CrMo44, 15CrMo3, 13CrMoV42,

cast steel GS17CrMo55, GS22CrMo54 - ASTM A335grP12 - ASTM A182grF12 - ASTM A387-gr11.

For joining of 13CrMo44 with 15Mo3.

Rebuilding worn out dies used in plastic industry.

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

C : 0.08 - 0.14	Mn : 0.80 - 1.20	Si : 0.40 - 0.80	Cr : 1.00 - 1.40	Mo : 0.40 - 0.60
P : < 0.02	S : < 0.02			

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)
≥ 355 MPa	≥ 510 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)	1.0	1.6	2.0	2.4	3.0
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Lenght (mm)	1000	1000	1000	1000	1000
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Tips & tricks

Preheat base metal at 200 °C to 300 °C dependent on base metal composition and thickness.

Post heat treatment can be required for some parent metals (650 °C).