

Lastek 1222 C

Creep and heat resistant steel

CLASSIFICATION

EN ISO 21952-A : W CRrMo2Si

AWS A5.28 : ER 90S-B3

GENERAL DESCRIPTION

Lastek 1222 C is a Cr-Mo alloyed Tig wire for joining heat resistant steels with a chromium content of approx. 2.5 % and a molybdenum content of approx. 1.2 %.

The deposit is heat resistant up to 600 °C (1110 °F).

Good welding properties, also in position.

APPLICATIONS

Steamproduction: boilers, overheating tubes, flanges, collectors, ...

Petrochemical industry.

Welding 10CrMo910, 10CrSiMoV7, GS12CrMo910, ...

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

C : 0.08	Si : 0.60	Mn : 0.60	Cr : 2.40	Mo : 1.00
Cu : < 0.25	P & S : < 0.01	Ni : < 0.20	V : < 0.01	Al : < 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)
≥ 450 MPa	≥ 580 MPa	≥ 20%	100-130 J (20 °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) 1.6 2.0 2.4

Lenght (mm) 1000 1000 1000

Tips & tricks

Preheating 200 °C to 300 °C depending on the base metal and workpiece thickness.

Stress-free annealing between 580 °C and 625 °C after welding is recommended for thicker pieces.

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.