

Lastek 1255 C

Rebuilding die casting moulds

CLASSIFICATION

EN ISO 21925-A : WCrMo5Si

AWS A5.28 : ER 80S-B6

GENERAL DESCRIPTION

TIG rod for welding Cr/Mo and Cr/Mo/V steel with 5% Cr.

The deposit has a high fatigue resistance, is resitant against thermal shocks and creep resistant.

Workingtemperatures up to 600 °C (1112 °F).

APPLICATIONS

Repairing die casting moulds and injection moulds.

Welding pipelines and boilers in the petrochemical industry (12CrMo 19 5 , wn°1.7362, 1.7363, ASTM A 335 gr P5).

Hardness: 32 HRC

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

C : < 0.10	Mn : 0.40 - 0.70	Si : < 0.50	Cr : 4.50 - 6.00	Mo : 0.45 - 0.65
Ni : < 0.60	P : < 0.025	S : < 0.025	Cu : < 0.35	Fe : Balance

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)
≥ 400 MPa	≥ 550 MPa	≥ 17%	≥ 60 J (R.T.)

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 depends on the type of base metal (as a guideline, use 300-350 °C (572-662 °F), for steel with 5% Cr).

Heattreatment after welding (steel with 5% Cr): 750 °C (1382 °F) - 1h + cooling in furnace.

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.