

Lastifil 10020

Solid welding wire for high strength steels

CLASSIFICATION

EN ISO 16834-A : G 89 4 M21 Mn4Ni2.5CrMo

AWS A5.28 : ER 120S-G

GENERAL DESCRIPTION

Lastifil 10020 is a solid, copper-plated wire for welding steels with high yield strength and tensile strength, such as S890QL, S960QL, S1100QL, HSLA steel, TMCP steel and QT steels.

Exceptional mechanical properties at low temperature (-40 °C).

APPLICATIONS

High strength steels for structures where the strength / weight ratio is very important.

Constructions subject to high stress, cranes, off-shore constructions, mobile constructions, ...

S890Q, S960Q, S890QL, S960QL, S1100QL.

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

C : 0.11	Mn : 1.90	Si : 0.70	P & S : < 0.015	Cr : 0.50
Ni : 2.50	Mo : 0.50			

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)
≥ 890 MPa	940 - 1180 MPa	≥ 15%	≥ 47 J (-40°C)

GENERAL INFORMATION

Welding positions All

Shielding gas Ar/CO₂, M21 (EN ISO 14175)

Packing 15 kg spool (in a cardboard box)

Polarity DC+

Diameter (mm) 0.8 1.0 1.2

Tips & tricks

Remove grease and impurities from the welding zone.

Respect pre-heating, interpass temperature and heat input depending on the base metal.

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.