

Lastifil 20 F

Self-shielding welding wire for all positions (multi pass).

CLASSIFICATION

EN ISO 17632-B : T49ZT11-1NA-H15

AWS A5.20 : E 71T-11

GENERAL DESCRIPTION

Self-shielded flux cored wire for all positions.

Smooth arc with low spatter.

Full slag coverage and easy slag removal.

Used for multi pass applications.

APPLICATIONS

For lap and fillet welds on thin gauge galvanized and mild steel.

For thin gauge materials in galvanized, zinc-aluminum carbon, or aluminised carbon steels.

General fabrication and civil constructions.

Automotive industry.

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

C : < 0.30	Si : < 0.60	Mn : < 1.75	Al : < 1.80	S : < 0.03
P : < 0.03	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	480 - 655 MPa	≥ 20%	

GENERAL INFORMATION

Welding positions All

Shielding gas NA

Packing 4.5 kg or 16 kg spool (in a cardboard box)

Polarity DC-

Diameter (mm) 1.0 1.2 1.6 2.4

Tips & tricks The use of DCEN (electrode negative) minimizes the risk of burn-through.

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.