

# Lastifil 20 TM

## Metal cored wire for high quality steel welding

### CLASSIFICATION

EN ISO 17632-A : T 46 6 M M 1 H5

AWS A5.18 : E 70C-6M H4

### GENERAL DESCRIPTION

Lastifil 20TM is a metal cored copper coated seamless wire. It has excellent welder appeal and superior arc stability. It produces spatter free welds, eliminating the need for costly cleaning.

Slag free weld beads allow for multi-pass welding without deslagging or worry of slag entrapment.

Lastifil 20TM combines the high deposition rate of flux cored wires with the low slag volume and the efficiency of solid wires.

(Deposition rate 7 to 10 kg/hr.)

The high current density characteristics allow for faster travel speeds than obtained with solid wires. Due to better root penetration a smaller joint angle can be used.

### APPLICATIONS

Boiler work, general plate and sheet metal fabrication, off shore constructions, all mild and medium tensile steels.

Structural steel: S185, S235 - S355 (EN 10025).

Boiler plate: P235GH, P265GH, P295GH (EN 10028-2).

Pipe steel: P235T1 - P355N (EN 10217-1); P235T2 - P355N (EN 10217-3); StE290.7TM - StE480.7TM (EN 10208-2).

API steel: X42 - X70.

Fine grain steel: StE355 - StE460 (EN 10028-3).

Hull steel grade A, B, D, E, AH32 - EH36.

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

<b>C :</b> < 0.08	<b>Mn :</b> 1.20 - 1.75	<b>Si :</b> 0.50 - 0.90	<b>P :</b> < 0.025	<b>S :</b> < 0.025
<b>Fe :</b> Balance				

### MECHANICAL PROPERTIES (Typical values, all weld metal)

Yield Strength N/mm <sup>2</sup>	Tensile Strength N/mm <sup>2</sup>	Elongation 5d (%)	Impact Strength Charpy V notch (ISO-V)
≥ 460 MPa	530 - 680 MPa	≥ 20%	≥ 47 J (-60°C)

### GENERAL INFORMATION

**Welding positions** All

**Shielding gas** Ar/CO<sub>2</sub>, M21 (EN ISO 14175)

**Packing** 16 kg spool (in a cardboard box)

**Polarity** DC+

**Diameter (mm)** 1.0 1.2 1.4 1.6

#### Tips & tricks

The coppered seamless wire can be welded with standard driving wheels but for smaller types of driving wheels the serrated wheels for tubular wire can work better.

*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.*