PRODUCT SPECIFICATION

# Lastek 1222

## Creepresistant steels 2Cr - 1Mo

## CLASSIFICATION

EN ISO 3580-A : E CrMo2 B 3 2
AWS A5.5 : E 9018-B3

## GENERAL DESCRIPTION

Lastek 1222 is a Cr-Mo alloyed electrode 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 :** 0.07 | **Mn :** 0.60 | **Si :** 0.50 | **Cr :** 2.20 | **Mo :** 1.10 |
| **P :** < 0.02 | **S :** < 0.02 | | | |

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

| Yield Strength N/mm² | Tensile Strength N/mm² | Elongation 5d (%) | Impact Strength Charpy V notch (ISO-V) |
|---|---|---|---|
| ≥ 400 MPa | ≥ 500 MPa | ≥ 18% | ≥ 47 J (20°C) |

## GENERAL INFORMATION

| | | | |
|---|---|---|---|
| **Welding positions** | All, except vertical down. | | |
| **Shielding gas** | NA | | |
| **Packing** | 5 kg in a plastic box | | |
| **Polarity** | DC, reverse polarity (electrode positive) | | |
| **Diameter (mm)** | 2.5 | 3.2 | 4.0 |
| **Lenght (mm)** | 350 | 350 | 350 |
| **Approx. current (A)** | 75 - 100 | 100 - 140 | 140 - 190 |

**Tips & tricks**
Maintain a short arc length, electrode almost vertical to the workpiece.
Use dry electrodes, dry them at least 2 hours at 300 °C (570 °F).
Preheating and heattreatment: follow the instructions of the base metal producer, or ask Lastek for advice.