

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/mm ²	Tensile Strength N/mm ²	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

Length (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.

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.