

Lastifil 41

Solid wire for welding cast iron

CLASSIFICATION

EN ISO 1071 : S C NiFe-1

AWS A5.15 : E NiFe-CI

GENERAL DESCRIPTION

Lastifil 41 is a Ni-Fe wire used for welding cast iron and ductile iron.

The wire is used for a range of repair and fabrication applications involving cast iron and ductile iron.

The wire is also suitable for dissimilar joints between cast iron and mild, low alloy and stainless steels.

TYPICAL USE

Applications include tanks and vessels, process pipework and heat exchangers, in chemical plants for salt production, chlorination and evaporation of caustic soda.

Also used for handling corrosive alkalis and halides.

Repair and rebuilding of standard grades of grey cast irons and malleable cast irons.

Machine bases, pump bodies, transmission housings, gears.

Hardness : 200HB

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

C : 0.10	Si : 0.20	Mn : 0.50	Ni : 58.00	Fe : Balance
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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)
≥ 230 MPa	≥ 400 MPa	≥ 24%	

GENERAL INFORMATION

Welding positions All

Shielding gas 98% Argon + 2% CO₂

Packing 15 kg spool (in a cardboard box)

Polarity DC+

Diameter (mm) 1.2

Tips & tricks Keep base material hand warm: do not exceed 100°C .
Short runs and peen the deposit in order to stress relieve .

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.