

Flux cored wire for welding cast iron**CLASSIFICATION**

EN ISO 1071 (T C NiFe T3-Cl)

GENERAL DESCRIPTION

Lastifil 41G is a flux cored wire specifically designed for welding of grey and nodular cast iron and for joining cast iron to steel and to other metals.

Using Lastifil 41G can yield important benefits in time for applications where large areas must be rebuilt (although all precautions for welding cast iron need to be respected).

There is practically no slag, which makes the wire very interesting for multiple layer build-up welding.

The deposit is porosity free, even after several layers.

Hardness: 140 - 160 HB

TYPICAL USE

Build-up of dies in automotive plants, rebuilding of coke oven doors, repair of foundry defects, repair of cast iron pumps and blowers.

Joining steel flanges to cast iron pipes (waste water).

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

C	Mn	Si	P	Fe	S	Ni
0.20	12.00	0.40	0.01	48.00	0.005	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)
≥ 320 MPa	≥ 500 MPa	≥ 20%	

General information

Welding positions: PA, PB

Shielding gas: Ar/CO₂ (M21: EN ISO 14175) or Ar/O₂ (M13: EN ISO 14175)

Dia (x length) (mm): 1.2 - 1.6

Packing: 15 kg spool (in cardboard box)

Polarity: DC, straight polarity.

Tips & tricks: Solid cast iron parts need to be preheated (80 - 120°C).
Use push welding (+/- 20 mm stickout).
A very thin slag layer could jump away when cooling down.
Wear goggles to protect your eyes.

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.