

 Welding technology	technical-metallurgical data sheet for LAWITEX - filler metals	LAWI 15 M
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This basis classifies also a guideline for quality protection.

Form: **filler metal**

LAWITEX-description **LAWI 15 M**

Cr-Mo-Mn filler metal with lowered carbon and silicon content. Cr-content is under 0,15 % and so it's nearly free of chrome-carbon. Additional elements which reduce the development of carbides. The welding deposit is polishable, erodable, nitrable, etchable and heat treatable. The laser welding is softer and lighter than LAWI 14 M.

Hardness 1- st layer approx. 300-360 HB.

Suitable for material no.: 1.2311, 1.2312, 1.2162, 1.2738 and similar.

Analyse % - steels

C	Al	Co	Cr	Cu	Fe	Mn	Mo	Ni	Si	V	W	Su%
0,12	0,03		<0,12	0,17	rest	1,1	0,50	<0,12		0,40		0,45

The technical results are dependent on the extent of mingling to the basic materials and also a indication of the process engineering.

Department of Quality