

 Welding technology	technical-metallurgical data sheet for LAWITEX - filler metals	LAWI 17 Ni
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This basis classifies also a guideline for quality protection.

Form: **filler metal**

LAWITEX-description **LAWI 17 Ni**

Ni-based laser filler metal with Cr-Mo-Mn-Fe-Co-Nb and elements to avoid hard carbide transitions. Rust- acid-, heatresisting and extremely cold resisting. Erodable and polishable. Cannot be nitrated, hardened and chromium-plated. For elastic basic, intermediate and joining layers. Crack safe welding of different steels and cast iron: GS, GG up to GG 70. Also best way to go on Alloy 625, 718, 725, 750 and 751.

Hardness 1-st layer approx. 210-250 HB, depending of energy and the diameter of the wire.

Stretching up to 46% max.

Tensile strength approx. 650-760 N/qmm².

Analyse % - steels

C	Al	Co	Cr	Cu	Fe	Mn	Mo	Ni	Si	Ti	Nb+Ta
<0,10	0,40	1,0	22,0	--	<5,0	0,50	8-10,0	Rest	0,40	0,40	3,50

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