

 Welding technology	technical-metallurgical data sheet for LAWITEX - filler metals	LAWI 18
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Manufacturer:
LAWITEX GmbH

Hitdorfer Str. 10 c, 40764 Langenfeld
Telefon: +49 - 21 73 – 399 1780
Fax: +49 - 21 73 – 399 1781
E-mail: info@lawitex.de

This basis classifies also a guideline for quality protection.

Form: **filler metal**

LAWITEX-description **LAWI 18**

Ni-basis laser filler metal with Cr-Mo-Mn-Fe-Nb and elements to avoid hard carbide transitions. Rust-acid-, heatresisting and extremely cold resisting. Erodable and polishable. Cannot be nitrated or chromium-plated. For elastic basic, intermediate and joining layers. Crack safe welding of different steels and cast iron: GS, GG-GG 70.

Hardness 1-st layer approx. 220-250 HB.

Stretching up to 46%!!

Tensile strength approx. 700-760 N/qmm².

Analyse % - steels

C	Al	Co	Cr	Cu	Fe	Mn	Mo	Ni	Si	V	W	Nb
0,02			19,5		1,9	2,8		Rest	0,2			2,5

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