

 Welding technology	technical-metallurgical data sheet for LAWITEX - filler metals	LAWI 22
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This basis classifies is also a guideline for quality protection.

Form: **filler metal**

LAWITEX-description **LAWI 22**

Nickel-based Cr-Mo-Mn-W-Fe filler metal for Tempering-, hardening steels and hot-work with universal properties. For nitrided steels, has edge stability and is resisting towards acid. Cannot be chromium-plated. Polishable, delayed erodability. Small thermal changeability of the structure. Hardness 1-st layer approx. 24-36 HRC. Increase of hardness by compression stress and dynamic compression stress till 35% !! Stretching approx. 18-25%.

Analyse % - steels

C	Al	Co	Cr	Cu	Fe	Mn	Mo	Ni	Si	V	W	Nb
0,05			19,0		2,1	3,0	1,0	Rest	0,30			3,0

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