

Creep resistant steels 2Cr – 1Mo**GENERAL DESCRIPTION**

Modi Lastek 1222 is a Cr-Mo alloyed electrode for joining heat resistant steels with a chromium content of approx. 2.5 % and a molybdenum content of approx. 1.2 %.

The deposit is heat resistant up to 600 °C (1110 °F).

Good welding properties, also in position.

APPLICATIONS

Steam production: boilers, overheating tubes, flanges, collectors, ...

Petrochemical industry.

Welding 10CrMo910, 10CrSiMoV7, GS12CrMo910, ...

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

C : 0.07	Mn : 0.60	Si : 0.50	Cr : 2.20	Mo : 1.10
P : < 0.02	S : < 0.02			

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)
≥ 400 MPa	≥ 500 MPa	≥ 18 %	≥ 47 J (20°C)

GENERAL INFORMATION

Welding positions	All, except vertical down		
Shielding gas	NA		
Packing	5 Kg in a plastic box		
Polarity	DC, reverse polarity (electrode positive)		
Diameter (mm)	2.5	3.2	4.0
Length (mm)	350	350	350
Approx. current (A)	75- 100	100 - 140	140 – 190

Tips & Tricks

Maintain a short arc length, electrode almost vertical to the workpiece.

Use dry electrodes, dry them at least 2 hours at 300 °C (570 °F).

Preheating and heat treatment: follow the instructions of the base metal producer, or ask Modi Lastek for advice