

Lastek 007

Universal construction electrode (root passes)

CLASSIFICATION

EN ISO 2560-A : E 42 0 RC 11

AWS A5.1 : E 6013

GENERAL DESCRIPTION

Electrode for welding steels with tensile strength up to 520 N/mm² (75ksi).

Universal use.

Easy arc ignition and a stable arc.

Excellent slag control, smooth beads and slag can easily be removed.

Can be used for root passes in pipe welding.

APPLICATIONS

All structural fabrication and repair works.

Structural steel: S185, S235 - S355 (EN 10025).

Boiler plate: P235GH, P265GH, P295GH (EN 10028-2).

Pipe steel: P235T1 - P355N (EN 10217-1); P235T2 - P355N (EN 10217-3); StE290.7TM - StE480.7TM (EN 10208-2).

API steel: X42 - X70 and fine grain steel: StE355 - StE460 (EN 10028-3).

Hull steel grade A, B, D, E, AH32 - EH36.

Cast steel GS38 - GS45.

Construction of boilers and pressure vessels.

Excellent for welding pipelines and making root passes.

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

C : 0.06 - 0.10	Mn : 0.35 - 0.70	Si : 0.30 - 0.60	P : < 0.02	S : < 0.02
Fe : Balance				

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)
≥ 420 MPa	500 - 640 MPa	≥ 20%	≥ 47 J (0°C)

GENERAL INFORMATION

Welding positions All

Shielding gas NA

Packing 5 kg in a cardboard box

Polarity AC or DC, straight polarity (electrode negative)

Diameter (mm)	2.0	2.5	3.2	3.2	4.0
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Lenght (mm)	350	350	350	450	450
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Approx. current (A)	40 - 70	60 - 90	85 - 130	85 - 130	120 - 170
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Tips & tricks

The information in this document is based on intensive tests and is accurate to the best of our knowledge. Do note that these values are only typical values for tests in accordance to prescribed standards. The suitability of the product should always be confirmed by qualification tests before use in any application. The information can be changed without previous notice.