

Lastek 1000

Cutting stainless steel and cast iron

CLASSIFICATION

GENERAL DESCRIPTION

Electrode with a special coating for electric cutting of all ferrous and non-ferrous metals without oxygen or compressed air. High speed cutting. Does not overheat and can be used completely. Stainless steel cutting gives clean cutting edges without carbon-deposits. Cutting plates in vertical as well as in horizontal position.

APPLICATIONS

Cutting all metals when conventional gas cutting equipment is not suitable: stainless steel, aluminium, cast iron, bronze, copper and so on.
 Many applications in boiler works.
 Dismantling of a defective ball bearing: Lastek 1000 is used to cut the outer ring, and Lastek 1001 to heat the inner ring.
 Demolition works.
 Piercing holes for bolts.
 Removal of rivets.

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

Fe : 60.00 - 70.00	Mn : < 2.00	Si : < 1.00	SiO₂ : 10.00 - 15.00	Fe₂O₃ : 15.00 - 25.00
K₂O : < 2.00				

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)

GENERAL INFORMATION

Welding positions	NA			
Shielding gas	NA			
Packing	5 kg in a plastic box			
Polarity	AC or DC, straight polarity (electrode negative)			
Diameter (mm)	2.5	3.2	4.0	5.0
Length (mm)	350	350	450	450
Approx. current (A)	120 - 160	160 - 250	200 - 350	260 - 390

Tips & tricks Electrode position: 90° to work piece.
 On thick pieces: make an up and down saw movement.

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.