

Lastek 8000

Joining carbon steel to stainless steel

CLASSIFICATION

EN ISO 3581-A : E 20 10 3 L R73

AWS A5.4 : E 308MoL

GENERAL DESCRIPTION

Electrode with 14% ferrite, recommended for joining steel to stainless steel.

Joining and surfacing carbon steel, spring steel, tool steel, manganese steel, stainless steel (AISI 304, 316, 1.4401, 1.4435).

Heat resistant up to 900 °C (1650 °F); Corrosion and wear resistant; High recovery (165 %).

The electrode does not become red-hot and can be entirely used even at high current.

L8000 welds with a very smooth arc and has a self releasing slag.

For carbon steel to stainless steel joints, the deposit is free of martensite up to dilution levels of 13%.

APPLICATIONS

Welding of flanges to stainless steel tubes.

Surfacing track links.

Welding wear resistant plates of unknown analysis.

Applying stainless protective layers on mild steel.

Base layer for hard facings.

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

C : 0.06	Cr : 17.50	Mo : 3.20	Mn : 0.60	Si : 1.00
Ni : 9.10	P : < 0.025	S : < 0.025		

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)
≥ 350 MPa	≥ 600 MPa	≥ 28%	≥ 65 J (R.T.)

GENERAL INFORMATION

Welding positions PA, PB, PC

Shielding gas NA

Packing 5 kg in a plastic box

Polarity AC or DC, reverse polarity (electrode positive)

Diameter (mm) 1.5 2.0 2.5 3.2 4.0

Lenght (mm) 250 250 350 350 350

Approx. current (A) 30 - 60 60 - 80 70 - 100 90 - 150 125 - 210

Tips & tricks

Keep a short arc and use a low current.

For welding stainless steel, the coating must not be damaged and it is recommended to return over the starting point of the bead.

When the electrodes have taken up humidity, dry them at 250°C (480°F) for 2 hours.

For optimum corrosion resistance on AISI 316L, use Lastek 804.

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.