

Lastek 804

High corrosion resistance, easy to polish

CLASSIFICATION

EN ISO 3581-A : E 19 12 3 L R 12

AWS A5.4 : E 316L-16

GENERAL DESCRIPTION

This electrode exhibits very high corrosion resistance, and deposits are easily polished.

It is an extra low carbon alloy, designed for welding 18/8 Mo austenitic stainless steels.

Very high and rapid deposition rate, excellent weld pool control, deposited beads are finely rippled and have a very aesthetic profile.

Heat input is very low, slag release is easy, provides porosity free deposits, with a glossy finish.

The deposited welds resist intergranular corrosion up to 350°C (662°F).

Use Lastek 801 to weld stabilized stainless steels that are used at higher working temperatures.

APPLICATIONS

Chemical, petrochemical and pharmaceutical industries.

Applications where chlorine ions can be encountered.

Marine environment applications, dairy and food processing equipment.

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

C : < 0.03	Si : 0.75 - 1.00	Mn : 0.55 - 1.50	Cr : 18.00 - 19.00	Ni : 11.00 - 12.00
Mo : 2.50 - 3.00	Cu : < 0.75			

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)
≥ 320 MPa	≥ 510 MPa	≥ 25%	≥ 55 J (20°C) / ≥ 32 J (-120°C)

GENERAL INFORMATION

Welding positions All, except vertical down.

Shielding gas NA

Packing 5 kg in a plastic box

Polarity AC or DC, reverse polarity (electrode positive)

Diameter (mm) 2.0 2.5 3.2 4.0

Length (mm) 300 300 350 350

Approx. current (A) 30 55 75 110

Tips & tricks Weld with minimal heat input, use lowest possible amperage.
Always use dry electrodes.
Use a stainless steel brush and chipping hammer.

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.