PRODUCT SPECIFICATION

Lastek 807 C

Joining difficult to weld steel and buffer layers for hard facing

CLASSIFICATION

EN ISO 14343-A : W 18 8 Mn
AWS A5.9 : ER 307Si

GENERAL DESCRIPTION

TIG rod for joining steels with poor weldability.
Exceptional crack resistance also on self-hardening or manganese steels.
Work hardens up to 400 HB under impact load without the slightest cracks and can therefore be used as a hard facing against wear and impact.
Oxidation resistant up to 850°C (1560°F).

APPLICATIONS

Welding of high alloyed, wear-resistant chrome steels (s.a. 3CR12 and related) and steels with poor weldability.
Welding stainless steel to carbon steel.
Joining and cladding workpieces with a 14% manganese content.
Base layer for extra hard facings on moulds and tools.
Surfacing rails and cams.
Welding workpieces subjected to shocks, impact and metal to metal friction.

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

C :	< 0.20	**Si :**	< 1.50	**Mn :**	5.00 - 8.00	**Cr :**	17.00 - 20.00	**Ni :**	7.00 - 10.00
P :	< 0.03	**S :**	< 0.03	**Mo :**	< 0.50	**Cu :**	< 0.50		

MECHANICAL PROPERTIES (Typical values, all weld metal)

Yield Strength N/mm²	Tensile Strength N/mm²	Elongation 5d (%)	Impact Strength Charpy V notch (ISO-V)
≥ 350 MPa	≥ 500 MPa	≥ 25%	≥ 50 J (R.T.)

GENERAL INFORMATION

Welding positions	NA		
Shielding gas	Argon		
Packing	5 kg in a cardboard box		
Polarity	DC, with the torch on the negative pole.		
Diameter (mm)	1.6	2.4	3.2
Lenght (mm)	1000	1000	1000

Tips & tricks