

Lastek 85 C

Crack-free welds on problem steels

CLASSIFICATION

EN ISO 14343-A : W 29 9

AWS A5.9 : ER 312

GENERAL DESCRIPTION

TIG welding rod for joining difficult to weld steel or for precision repair on dies.

Very high tensile strength, shock resistant and ductile.

Because of the high chromium content, Lastek 85C is oxidation resistant up to 1.150 °C (2.100 °F).

The high ferrite content guarantees crack-free assemblies when welding stainless steel to carbon steel, even at a high dilution.

APPLICATIONS

Joining and refacing high carbon steel, tool steel, spring steel, manganese steel, cast steel.

Wear resistant layers on dies and edges.

Hardness: 260 HB (work hardens up to approx 450 HB).

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

C : < 0.15	Mn : 1.50 - 2.20	Si : 0.30 - 0.65	Cr : 28.00 - 32.00	Ni : 8.00 - 10.50
Mo : < 0.75	Cu : < 0.75	S : < 0.03	P : < 0.03	

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)
≥ 450 MPa	≥ 650 MPa	≥ 22%	≥ 47 J (20°C)

GENERAL INFORMATION

Welding positions NA

Shielding gas Argon (or Helium)

Packing 5 kg in a cardboard box

Polarity DC, with the torch on the negative pole.

Diameter (mm) 1.0 - 3.2

Length (mm) 1000

Tips & tricks For refacings with the oxy acetylene flame use flux 802CA

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.