PRODUCT SPECIFICATION

Lastek 88

Welding thin steel sheets

CLASSIFICATION

EN ISO 2560-A : E 42 0 RR12
AWS A5.1 : E 6013

GENERAL DESCRIPTION

Special contact electrode for welding thin steel sheets starting from 0.8 mm.
Gives very smooth and flat weld beads, without undercut.
Welded parts can be painted or galvanized without prior machining.
Lastek 88 is also suitable for spot welding of thin plates and plates of different thickness.
Can be used for pore-free welding of galvanized plates. (Because of the very low amperages the zinc layer at the bottom side will be not or hardly damaged)
Self-releasing slag.

APPLICATIONS

Carriage work, steel furniture, steel doors, tubular constructions for ventilation and airducts.
All kind of apparatus and thin sheets, like: gassradiators, household apparatus,…

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

C : 0.05 - 0.10	**Mn :** 0.50 - 0.75	**Si :** 0.40 - 0.65	**P :** < 0.025	**S :** < 0.02
Fe : Balance				

MECHANICAL PROPERTIES (Typical values, all weld metal)

Yield Strength N/mm²	Tensile Strength N/mm²	Elongation 5d (%)	Impact Strength Charpy V notch (ISO-V)
≥ 440 MPa	500 - 640 MPa	≥ 22%	≥ 50 J (0°C) / ≥ 70 J (20°C)

GENERAL INFORMATION

Welding positions	All, except vertical down.		
Shielding gas	NA		
Packing	5 kg in a plastic box		
Polarity	AC or DC, straight polarity (electrode negative)		
Diameter (mm)	1.5	2.0	2.5
Lenght (mm)	250	300	350
Approx. current (A)	30 - 40	50 - 70	70 - 95

Tips & tricks Electrode to be held at 30 to 40° to the workpiece and drawn quickly forwards.
Use the lowest possible amperage for fillet welds, to avoid slag burn-in.