

Lastek 95

Welding massive work pieces

CLASSIFICATION

EN ISO 3581-A / EN ISO 14700 : E 18 8 Mn R 73 / E Fe 10
AWS A5.4 : ~E 307-26

GENERAL DESCRIPTION

Austenitic electrode with a universal application field especially for assemblies requiring high tensile strength and elongation. V groove joints can be filled by fillet welding without cracking danger, even in very thick materials.

APPLICATIONS

Welding of die steels, alloy steels, stainless chromium steels, non magnetic steels and cast steels with unknown impurities. Especially recommended for thick sections.

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

C : < 0.09	Cr : 19.00	Mn : 5.00	Si : 1.50	Ni : 9.50
P : < 0.025	S : < 0.025	Fe : Balance		

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)
≥ 500 MPa	≥ 700 MPa	≥ 35%	

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) 2.5 3.2 4.0

Length (mm) 350 350 350

Approx. current (A) 70 - 90 90 - 140 130 - 180

Tips & tricks

Remove all traces of oil or grease.

Depending on the tempering temperature used, die-steel can be preheated up to 250-550°C.

Chromium steel (13-17% Cr) is preheated up to 200-300°C.

Manganese steel (14%) should be cold-welded without any preheat.

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.