PRODUCT SPECIFICATION

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/mm²	Tensile Strength N/mm²	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
Lenght (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.