PRODUCT SPECIFICATION

# Lastek 1900

## Gouging and grooving

## CLASSIFICATION

## GENERAL DESCRIPTION

Lastek 1900 melts and blows away any metal (from stainless steel to cast iron or copper alloys) with a standard AC or DC power source.
The highly concentrated blowing action removes any grease or oil or excess carbon on cast iron and leaves a clean groove, free of stuck molten particles.
On stainless steel, there is less oxidation compared with other air or oxygen based cutting processes, due to the protection of the weld zone with ionized elements from the coating.
Can be used on spots that can't be reached with a grinding wheel.

## APPLICATIONS

Preparing weld repairs on cast iron: just fit the broken parts together, gouge a groove and positioning always remains correct.
Removing flash and risers in foundries.
Veeing out cracks in any steel structure prior to welding.
Removing old hard faced layers prior to rebuilding.
Bevelling of all metals.

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

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## MECHANICAL PROPERTIES (Typical values, all weld metal)

| Yield Strength N/mm² | Tensile Strength N/mm² | Elongation 5d (%) | Impact Strength Charpy V notch (ISO-V) |
|---|---|---|---|
| | | | |

## GENERAL INFORMATION

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|---|---|---|---|---|
| **Welding positions** | All | | | |
| **Shielding gas** | NA | | | |
| **Packing** | 5 kg in a plastic box | | | |
| **Polarity** | AC or DC, straight polarity (electrode negative) | | | |
| **Diameter (mm)** | 2.5 | 3.2 | 4.0 | 5.0 |
| **Lenght (mm)** | 350 | 350 | 350 | 450 |
| **Approx. current (A)** | 90 - 150 | 130 - 240 | 180 - 300 | 220 - 350 |

**Tips & tricks**

DC straight polarity produces the fastest grooves, but AC may also be used.
Keep the angle between electrode and work piece between 6 and 20 degrees (more amps can be used with a lower angle to go faster and to get a cleaner groove).
Keep the electrode in contact with the base metal.
Push the electrode forwards to produce a shallow groove. For a deeper cut, repeat the operation.