PRODUCT SPECIFICATION

Lastek 90

% lastek

High strength - soft arc

CLASSIFICATION

EN ISO 3581-A : E 29 9 R12 AWS A5.4 : E 312-16

GENERAL DESCRIPTION

Exceptional mechanical characteristics.

Recommended for all steels that are difficult to weld.

Highly alloyed with Ni, Cr and Mn.

The deposited material is very tough, crack-free, and has an exceptional resistance to shocks and fatigue.

Good resistance to wear, corrosion and heat.

Very soft arc, with minimum spatter and no undercut.

APPLICATIONS

Wear plates for waste disposal, teeth of dredger buckets.

Repair of cracked buckets and scoops.

Repair of tractor-platforms, rear axle and fellies of trucks, leaf springs, broken crank shafts.

Base layer for surfacings on problem steels.

Repair of broken cutting tools.

Wear-resistant surfacing of machine parts e.g. plastic injection moulds.

Hardness: 220 HB

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

C:	0.10	Cr : 28.00	Mo: 0.25	Mn : 1.00	Si : 1.50
Ni:	12.00	Fe: Balance			

MECHANICAL PROPERTIES (Typical values, all weld metal)

Yield Strength	Tensile Strength	Elongation	Impact Strength
N/mm²	N/mm²	5d (%)	Charpy V notch (ISO-V)
	890 MPa	≥ 28%	

GENERAL INFORMATION

Welding positions	All, except vertical down.							
Shielding gas	NA							
Packing	5 kg in a plastic box							
Polarity AC or DC, reverse polarity (electrode positive)								
Diameter (mm)	1.5	2.0	2.5	3.2	4.0			
Lenght (mm)	250	250	275	300	350			
Approx. current (A)	15 - 35	20 - 50	30 - 65	45 - 125	80 - 160			

Tips & tricks Use a short arc, electrode position almost 90° to the workpiece.

Allow each weld bead to cool slightly before making a further deposit.

For welding on crack sensitive steels, pre-heat the work piece until it reaches the tempering temperature of the steel.

Avoid rapid cooling.

12-14% Manganese steel is always welded cold (max 350 ° C).

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.

www.lastek.be PSEN_L90_N0523_TW