

Lastek 85

Joining dissimilar metals and difficult to weld steels

CLASSIFICATION

EN ISO 14700 (E Fe11)
A5.4 (E 312-16)

GENERAL DESCRIPTION

Highly alloyed electrode for joining and surfacing tool steel, spring steel, manganese steel, carbon steel and all difficult to weld steels and dissimilar metals.

The deposit has exceptional tensile strength and resistance to cracking.

Oxidation resistant up to 900 °C (1650 °F).

Even on dirty metal, porous-free welds can be obtained.

Stable arc, almost no spatters.

Smooth welds, without undercut.

TYPICAL USE

Joining of broken tools and dies, cast steel, abrasion resistant steel.

Copper and carbon steel to stainless steel.

Repair of hydraulic rams, bulldozer buckets and teeth, gears.

The work hardening characteristics and the high chromium content make Lastek 85 suitable for surfacing on rails and bearing areas, on plastic extrusion tools and cutting edges.

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

C	Cr	Mn	Si	Ni	Fe
0.11	30.0	1.80	0.46	9.50	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)
≥ 700 MPa	≥ 820 MPa	≥ 21%	≥ 33 J (R.T.)

General information

Welding positions: All, except vertical down.

Shielding gas: NA

Dia (x length) (mm): 2.5 (x 275) / 3.2 (x 300) / 4.0 (x 350) / 5.0 (x 450)

Packing: 5 kg in plastic box

Polarity: AC or DC, reverse polarity (electrode positive)

Tips & tricks: Electrode to be held almost at 90° to the work piece with shortest possible arc. Allow each weld bead to cool slightly before making a further deposit.
On problem steels, cover the welded area with insulating material in order to avoid a rapid cooling.

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.