Modi Lastek 43

Special electrode for ground layer on cast iron

GENERAL DESCRIPTION

Modi Lastek 43 has been developed for the repair of "unweldable" cast iron, where Ni base electrodes do not give a solid bond. The special coating develops a powerful cleaning action. The aggressive arc penetrates through the oxidised or contaminated surface and provides a perfect bond.
Modi Lastek 43 absorbs the carbon from the cast iron and the deposit becomes hard and nonmachinable.
Modi Lastek 43 should be used as a buttering run in the groove made with Lastek 1900.
The beads should not touch. The joint is finished with electrodes such as Modi Lastek 40E, 42E or 41E.

APPLICATIONS

Welding all poor quality cast iron, reclamation on ship motor blocks, oxidised furnace parts, repairing foundry defects for colour match, first layer on cast iron prior to hardfacing (spreader cones in brick extrusion machinery, cast iron gears.)

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

C : 0.03	Mn : 0.15	Si : 0.10	Fe : 99.00	P : < 0.015
S : < 0.015				

MECHANICAL PROPERTIES (Typical values, all weld metal)

Yield Strength N/mm²	Tensile Strength N/mm²	Elongation 5d (%)	Impact Strength Charpy V notch (ISO-V)
	≥ 390 MPa	≥ 30 %	

GENERAL INFORMATION

Welding positions	All	
Shielding gas	NA	
Packing	5 Kg in a plastic box	
Polarity	AC or DC, reverse polarity (electrode positive)	
Diameter (mm)	3.2	4.0
Length (mm)	350	350
Approx. current (A)	100 - 120	120 – 140

Tips & Tricks	Weld with a weaving motion in the direction of travel. During the forward motion the arc bites into the cast iron. During the backward motion Modi Lastek 43 deposits a droplet on the previous deposit.