PRODUCT SPECIFICATION

Modi Lastek 9067

Electrode for joining dissimilar metals with highest crack resistance

GENERAL DESCRIPTION

Lastek 9067 is a high nickel electrode used in the assembly of Ni-Cr-Mo alloys such as Inconel 625 and several Hastelloy types. The weld deposit is very corrosion resistant. In high temperature applications it is resistant against oxidation up to 1200 °C (2200 °F). Lastek 9067 permits dissimilar joints between austenitic CrNiMo-steels and nickel base alloys.

APPLICATIONS

Chemical and petrochemical industry.
Surfacing and repairing of moulds and dies.
Corrosion resistant overlays in off-shore constructions and in marine equipment.
Joint welds and welding overlays in heat treatment equipment.

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

C : 0.03	Mn : < 2.00	Cr : 20.00 – 23.00	Ni : > 58 (Rest)	Mo : 8.00 – 10.00
Si : < 0.75	Nb+Ta : 2.00 – 4.00	Fe : < 0.6	Cu : < 0.5	P :< 0.03 | 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)
	760 MPa	≥ 30 %	

GENERAL INFORMATION

Welding positions		
Shielding gas	NA	
Packing	5 Kg in a plastic box	
Polarity	Ac or DC, reverse polarity (DCEP)	
Diameter (mm)	2.5	3.2
Length (mm)		
Approx. current (A)	70 - 90	110 - 130

Tips & Tricks

Use a short arc. Use stringer beads (don't weave).
Electrodes have to be dry before use.
Welding zone should be thoroughly cleaned before welding.
All traces of sulphur and lead present in grease, oil, layers of paint and marking crayons have to be removed. The cleaning agent has to be washed off with hot water.
Oxide layers have to be removed by grinding or with a stainless steel brush.