PRODUCT SPECIFICATION

Modi Lastek 10015

Welding low alloy high strength steels

GENERAL DESCRIPTION

Low hydrogen electrode for welding quenched and tempered or micro alloyed steels.
The Charpy V impact strength is high, also at subzero temperatures.
It has an excellent welder appeal thanks to the specific composition of the coating.
This coating is moisture resistant.

APPLICATIONS

Welding of T1 steel, HY80, NAXTRA65,70, Superelso, Superelso 700.
For boilers, tanks, dredging equipment, construction, - excavating-, mining equipment.
Welding of high strength rails.
Repair on forklifts.
Heavy machinery.

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

C : 0.03 – 0.10	Mn : 1.40 – 2.00	Si : < 0.60	Cr : 030 – 0.60	Ni : 1.80 – 2.60
Mo : 0.30 – 0.60	P : < 0.02	S : < 0.02		

MECHANICAL PROPERTIES (Typical values, all weld metal)

Yield Strength N/mm²	Tensile Strength N/mm²	Elongation 5d (%)	Impact Strength Charpy V notch (ISO-V)
≥ 690 MPa	760 - 960 MPa	≥ 18 %	≥ 47 J (-40°C)

GENERAL INFORMATION

Welding positions	All			
Shielding gas	NA			
Packing	5 Kg in a plastic box			
Polarity	DC, reverse polarity (electrode positive) – for root pass use straight polarity			
Diameter (mm)	2.5	3.2	4.0	5.0
Length (mm)	350	350	450	450

Tips & Tricks

Clean the weld area and weld with a short arc.
Use stringer beads and avoid weaving for the highest mechanical characteristics.
If required, dry the electrodes at 250-300 °C (480-570 °F) for 2 hours.
Open circuit voltage: 70 V