PRODUCT SPECIFICATION

Modi Lastek 11017

High impact strength

GENERAL DESCRIPTION

Basic electrode for fine grained or Ni-alloyed steels with a high yield strength and impact value.
Easily removable slag.
Perfectly suitable for welding Corten steel

APPLICATIONS

Pressure vessels, bridges, machine constructions, shipbuilding, machine supports, tanks and pipes.
Constructions subjected to severe weather conditions.

Impact Strength Av (ISO V):
@ 20 °C > 135 J
@ 0 °C > 120 J
@-20 °C > 100 J
@-40 °C > 60 J

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

C : 0.06	Si : 0.50	Mn : 1.60	Ni : 0.90	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)
≥ 510 MPa	590 - 690 MPa	≥ 23 %	≥ 47 J (-60°C)

GENERAL INFORMATION

Welding positions	All, except vertical down		
Shielding gas	NA		
Packing	5 Kg in a plastic box		
Polarity	DC, reverse polarity (electrode positive)		
Diameter (mm)	2.5	3.2	4.0
Length (mm)	350	450	450
Approx. current (A)	60 - 90	90 - 135	140 - 180

Tips & Tricks

Maintain a short arc, the electrode almost in vertical position to the work piece.
Avoid porosities by striking the arc on a spare piece of metal. Renew this procedure for each weld. At the end of the bead come back with the arc on the deposit to avoid crater-formation.
Always use very dry electrodes to obtain the highest possible mechanical characteristics.
When necessary, preheat and dry the electrodes in the Lastidry for 2 h at 300 °C (570 °F)