

Universal construction electrode**GENERAL DESCRIPTION**

Electrode with a special coating which is almost insensible to moisture pick-up.

Due to the intensive arc and the easily controlled slag, Modi Lastek 005 is very suitable for welding badly prepared, rusted, painted, oily or dirty pieces.

APPLICATIONS

Construction of boilers, tanks, vehicles and machinery.

Repair welding and modifications of old or dirty constructions.

Welding jobs in open-air, exposed to humidity and moisture.

Structural steel: S185, S235 - S355 (EN 10025).

Boiler plate: P235GH, P265GH, P295GH (EN 10028-2).

Pipe steel: P235T1 - P355N (EN 10217-1); P235T2 - P355N (EN 10217-3); StE290.7TM - StE480.7TM (EN 10208-2).

API steel: X42 - X70 and fine grain steel: StE355 - StE460 (EN 10028-3).

Hull steel grade A, B, D, E, AH32 - EH36.

Cast steel GS38 - GS45.

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

C : 0.06 – 0.10	Mn : 0.35 – 0.70	Si : 0.30 – 0.60	P : < 0.025	S : < 0.025
Fe : 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)
≥ 380 MPa	470 - 600 MPa	≥ 24 %	≥ 47 J (0°)

GENERAL INFORMATION

Welding positions	All		
Shielding gas	NA		
Packing	5 Kg in a plastic box		
Polarity	AC or DC, straight polarity (electrode negative)		
Diameter (mm)	2.5	3.2	4.0
Length (mm)	350	350	350
Approx. current (A)	60 - 90	80 - 130	130 - 160

Tips & Tricks

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.