

Low hydrogen (basic) electrode for high mechanical characteristics**GENERAL DESCRIPTION**

All positional low hydrogen electrode for high-quality joining of highly strained constructions.
A fluid slag permits a good visibility on the molten pool for vertical up welding.
Modi Lastek 1130 has a very stable arc and can be used for root passes.

APPLICATIONS

Structural steel fabrication of "I" and "H3 beams, pipe lines and for tube to plate welds.
Machine and frame fabrication, machine supports, shafts of trailers, reservoirs.

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

C : 0.05 – 0.10	Mn : 1.00 – 1.30	Si : 0.55 – 0.80	P : < 0.02	S : < 0.02
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)
≥ 420 MPa	500 – 640 MPa	≥ 22 %	≥ 47 J (-30°C)

GENERAL INFORMATION

Welding positions	All			
Shielding gas	NA			
Packing	5 Kg in a cardboard box			
Polarity	AC or DC, reverse polarity (electrode positive) – for root pass use straight polarity			
Diameter (mm)	2.5	3.2	3.2	4.0
Length (mm)	350	350	450	350
Approx. current (A)	60 - 85	90 - 130	90 - 130	120 - 180

Tips & Tricks

Use a short arc, keep the electrode at an angle of 90° to the work piece.
Always use very dry electrodes to obtain the highest possible mechanical characteristics.
Preheat and dry electrodes for 2 hours at 300 °C (572 °F).

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.