

Welding galvanizing baths in Armco-iron**GENERAL DESCRIPTION**

Weld deposit with extra low carbon and silicon content.
Welding of mild steel that has to be Zinc coated.
Smooth welding beads.

APPLICATIONS

Modi Lastek 17 can be used to weld Armco iron, that is resistant to molten zinc at 475 °C (887 °F) due to its low carbon and silicon content.
Modi Lastek 17 is also useful for welding mild steel that has to be galvanised. The zinc coating will be more uniform than with other filler metals.

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

C : 0.06	Mn : 0.34	Si : 0.09	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)
	450 MPa	≥ 15 %	

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)	3.2	4.0
Length (mm)	350	350
Approx. current (A)	80 - 130	110 - 160

Tips & Tricks Modi Lastek 17 can be welded in contact with the work piece.
Use a high welding speed, the electrode inclined at an angle of 60-70°.
Open circuit voltage 70 V minimum on AC.

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.