

Welding thin steel sheets

GENERAL DESCRIPTION

Special contact electrode for welding thin steel sheets starting from 0.8 mm.

Gives very smooth and flat weld beads, without undercut.

Welded parts can be painted or galvanized without prior machining.

Lastek 88 is also suitable for spot welding of thin plates and plates of different thickness.

Can be used for pore-free welding of galvanized plates. (Because of the very low amperages the zinc layer at the bottom side will be not or hardly damaged)

Self-releasing slag.

APPLICATIONS

Carriage work, steel furniture, steel doors, tubular constructions for ventilation and airducts.

All kind of apparatus and thin sheets, like: gas radiators, household apparatus,...

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

| | | | | |
|-----------------|------------------|------------------|-------------|------------|
| C : 0.05 – 0.10 | Mn : 0.50 – 0.75 | Si : 0.40 – 0.65 | P : < 0.025 | 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) |
|-------------------------------------|---------------------------------------|----------------------|---|
| ≥ 440 MPa | 500 - 640 MPa | ≥ 22 % | ≥ 50 J (0°C) / ≥ 70 J (20°C) |

GENERAL INFORMATION

| | | | |
|----------------------------|--|---------|---------|
| Welding positions | All, except vertical down | | |
| Shielding gas | NA | | |
| Packing | 5 Kg in a plastic box | | |
| Polarity | AC or DC, straight polarity (electrode negative) | | |
| Diameter (mm) | 1.5 | 2.0 | 2.5 |
| Length (mm) | 250 | 300 | 350 |
| Approx. current (A) | 30 - 40 | 50 - 70 | 70 - 95 |

Tips & Tricks

Electrode to be held at 30 to 40° to the workpiece and drawn quickly forwards.
Use the lowest possible amperage for fillet welds, to avoid slag burn-in.

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.