

**Joining carbon steel to stainless steel****GENERAL DESCRIPTION**

Electrode with 14% ferrite, recommended for joining steel to stainless steel.

Joining and surfacing carbon steel, spring steel, tool steel, manganese steel, stainless steel (AISI 304, 316, 1.4401, 1.4435).

Heat resistant up to 900 °C (1650 °F); Corrosion and wear resistant; High recovery (165 %).

The electrode does not become red-hot and can be entirely used even at high current.

Modi Lastek 8000 welds with a very smooth arc and has a self releasing slag.

For carbon steel to stainless steel joints, the deposit is free of martensite up to dilution levels of 13%.

**APPLICATIONS**

Welding of flanges to stainless steel tubes.

Surfacing track links.

Welding wear resistant plates of unknown analysis.

Applying stainless protective layers on mild steel.

Base layer for hard facings.

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

C :	0.06	Cr :	17.50	Mo :	3.20	Mn :	0.60	Si :	1.00
Ni :	9.10	P :	< 0.025	S :	< 0.025				

**MECHANICAL PROPERTIES (Typical values, all weld metal)**

Yield Strength N/mm <sup>2</sup>	Tensile Strength N/mm <sup>2</sup>	Elongation 5d (%)	Impact Strength Charpy V notch (ISO-V)
≥ 350 MPa	≥ 600 MPa	≥ 28 %	≥ 65 J (R.T.)

**GENERAL INFORMATION**

<b>Welding positions</b>	PA, PB, PC				
<b>Shielding gas</b>	NA				
<b>Packing</b>	5 Kg in a plastic box				
<b>Polarity</b>	Ac or DC, reverse polarity (electrode positive)				
<b>Diameter (mm)</b>	1.5	2.0	2.5	3.2	4.0
<b>Length (mm)</b>	250	250	350	350	350
<b>Approx. current (A)</b>	30 - 60	60 - 80	70 - 100	90 - 150	125 - 210

**Tips & Tricks**

Keep a short arc and use a low current.

For welding stainless steel, the coating must not be damaged, and it is recommended to return over the starting point of the bead.

When the electrodes have taken up humidity, dry them at 250°C (480°F) for 2 hours.

For optimum corrosion resistance on AISI 316L, use Modi Lastek 804.

*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.*