

Heat and corrosion resistant**GENERAL DESCRIPTION**

Joining austenitic, refractory Cr-Ni steels like AISI 310, 314, 309... Material number 1.4841, 1.4843, 1.4845, 1.4828, ... cast steel ACI HK. Repair welding of austenitic cast iron like Ni-Resist® or abrasion resistant cast iron like Ni-Hard®.

Heat resistant weld overlays for temperatures up to 1200 °C.

For applications in an atmosphere of sulphuric gases (sulphur dioxide and especially hydrosulphide vapours) apply a protective layer with Modi Lastek 806 after welding the joint with Modi Lastek 802.

Welding clad steel. Recommended for welding armoured steels and steels with high carbon content.

APPLICATIONS

Heat treating: furnace tubes, burner nozzles, fixtures...

Cement industry: kiln chains, kiln feed chutes, ...

Petroleum and petrochemical industry: pumps, tubes, tube sheets, ...

Melting and refining equipment.

Pulp and paper: digesters, filter press plates and frames, mixing kettles.

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

C :	0.10	Si :	0.85	Mn :	1.20	Cr :	25.00	Ni :	20.00
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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)
≥ 350 MPa	≥ 550 MPa	≥ 20 %	NPD

GENERAL INFORMATION

Welding positions	All, except vertical down				
Shielding gas	NA				
Packing	5 Kg in a plastic box				
Polarity	Ac or DC, reverse polarity (electrode positive)				
Diameter (mm)	2.0	2.5	3.2	4.0	5.0
Length (mm)	250	250	350	350	350
Approx. current (A)	25 - 40	50 - 70	60 - 90	100 - 140	140 - 160

Tips & Tricks Weld with minimum heat input: short arc, low amperage, electrode almost vertical to the work piece.
Use dry electrodes.
If necessary: redry at 250°C for 1 or 2 hours.

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.