PRODUCT SPECIFICATION

Modi Lastek 803

Welding 18/8 austenitic stainless steel with low carbon content

GENERAL DESCRIPTION

Electrode with a quiet arc and excellent weld pool control.
Deposited beads are finely rippled and have a very aesthetic profile.
Heat input is very low and slag release is easy.
Provides porosity free deposits, with a glossy finish.
The deposited welds resist intergranular corrosion up to 350°C (662°F).
Use Lastek 800 to weld stabilized stainless steels that are used at higher working temperatures.

APPLICATIONS

For use on 304L, 304 (weld deposit 308L).
Household appliance manufacturing, industrial kitchen applications, medical equipment, pharmaceutical, chemical and petrochemical industry, condensers, piping and so on.

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

C : < 0.03	Mn : < 2.00	Si : < 1.20	Cr : 18.00 – 21.00	Ni : 9.00 – 11.00
P : < 0.025	S : < 0.025			

MECHANICAL PROPERTIES (Typical values, all weld metal)

Yield Strength N/mm²	Tensile Strength N/mm²	Elongation 5d (%)	Impact Strength Charpy V notch (ISO-V)
≥ 320 MPa	≥ 510 MPa	≥ 30 %	≥ 55 J (20°C) / ≥ 30 J (-196°C)

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
Length (mm)	300	300	350	350
Approx. current (A)	25 - 40	50 - 70	60 - 90	100 - 140

Tips & Tricks

Weld with minimal heat input, use lowest possible amperage.
Always use dry electrodes.
Use a stainless steel brush and chipping hammer.