PRODUCT SPECIFICATION

Modi Lastek 804

High corrosion resistance, easy to polish

GENERAL DESCRIPTION

This electrode exhibits very high corrosion resistance, and deposits are easily polished.
It is an extra low carbon alloy, designed for welding 18/8 Mo austenitic stainless steels.
Very high and rapid deposition rate, excellent weld pool control, deposited beads are finely rippled and have a very aesthetic profile.
Heat input is very low, 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 Modi Lastek 801 to weld stabilized stainless steels that are used at higher working temperatures.

APPLICATIONS

Chemical, petrochemical and pharmaceutical industries.
Applications where chlorine ions can be encountered.
Marine environment applications, dairy and food processing equipment.

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

C : < 0.03	Si : 0.75 – 1.00	Mn : 0.55 – 1.50	Cr : 18.00 – 19.00	Ni : 11.00 – 12.00
Mo : 2.50 – 3.00	Cu : < 0.75			

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	≥ 25 %	≥ 55 J (20°C) / ≥ 32 J (-120°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)	30	55	75	110

Tips & Tricks

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