

Stainless steel electrode – vertical down**GENERAL DESCRIPTION**

Vertical down welding of all common corrosion resistant CrNiMo and CrNi steels (as AISI 304, 304L, 316, 316L, Wn° 1.4301, 1.4306, 1.4550, 1.4401, 1.4404).

Vertical down welding can be performed much more rapidly, which will shorten the production time. Also, the heat-input in the material is much lower, which has a favourable influence on tensions and distortion in light gauge metal. It will also limit the post weld cleaning work to a minimum (surface discoloration is much smaller, so less pickling is required).

Modi Lastek 805 has a stable arc, gives almost no spatters and the welding beads have a smooth appearance.

It permits easy root pass welding of open joints in stainless steel.

APPLICATIONS

Chemical and petrochemical industry, food industry, hospitals, pharmaceutical industry, industrial kitchen installations, sea transport. If danger from corrosion by nitric acid is a problem it is desirable to use Modi Lastek 800 or 803.

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

C : < 0.03	Si : 0.60 – 1.20	Mn : 0.50 – 1.50	Cr : 18.00 – 19.00	Ni : 9.00 – 11.00
S : < 0.02	Mo : 2.00 – 3.00	P : <0.03		

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	≥ 30 %	≥ 65 J (20°C)

GENERAL INFORMATION

Welding positions	All		
Shielding gas	NA		
Packing	5 Kg in a plastic box		
Polarity	Ac or DC, electrode either to the + or - pole (see Tips & Tricks)		
Diameter (mm)	2.0	2.5	3.2
Length (mm)	250	250	350
Approx. current (A)	10 - 40	30 - 70	60 - 110

Tips & Tricks

For the root pass in an open joint and the first pass in a corner joint, it is preferable to weld with the electrode on the negative pole when using direct current.

Weld with a short arc at high speed, use the lowest amperage possible.

Use only dry electrodes.

Use a stainless steel brush and chipping hammer.

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.