PRODUCT SPECIFICATION

Modi Lastek 807

Joining of - and buffer layers on problem steels

GENERAL DESCRIPTION

Modi Lastek 807 is a high strength, ductile, crack resistant electrode designed for welding problem steels such as high carbon and crack sensitive tool steels or manganese steel.
Heat resistant up to 850 °C (1560 °F).
Rust proof.
Recommended for hard facings; High resistance to wear and heavy shocks.
High recovery (160 %).

APPLICATIONS

Joining of highly alloyed and difficult to weld steel.
Surfacing and repair of excavator's buckets.
Joining and surfacing of rails and steel with 14 % manganese.
Cushion layer for hard facings.
Surfacing of rollers, crane-wheels, …

Hardness: +/- 200 HB as welded and +/- 450 HB after work hardening.

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

C : < 0.10	Si : 1.00 – 2.00	Mn : 4.00 – 6.00	Cr : 18.00 – 20.00	Ni : 9.00 – 10.50
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)
≥ 450 MPa	≥ 610 MPa	≥ 40 %	

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)	2.5	3.2	4.0	5.0
Length (mm)	350	350	350	450
Approx. current (A)	70 - 90	90 - 140	130 - 180	160 – 230

Tips & Tricks

Keep the arc as short as possible. Electrode position almost 90° to the workpiece.
For welding 14% Mn-steel, keep the temperature of the workpiece below 350 °C (660 °F)