PRODUCT SPECIFICATION

Modi Lastek 1000

Cutting stainless steel and cast iron

GENERAL DESCRIPTION

Electrode with a special coating for electric cutting of all ferrous and non-ferrous metals without oxygen or compressed air.
High speed cutting. Does not overheat and can be used completely.
Stainless steel cutting gives clean cutting edges without carbon-deposits.
Cutting plates in vertical as well as in horizontal position.

APPLICATIONS

Cutting all metals when conventional gas cutting equipment is not suitable: stainless steel, aluminium, cast iron, bronze, copper and so on.
Many applications in boiler works.
Dismantling of a defective ball bearing: Modi Lastek 1000 is used to cut the outer ring, and Modi Lastek 1001 to heat the inner ring.
Demolition works.
Piercing holes for bolts.
Removal of rivets.

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

Fe : 60.00 – 70.00	Mn : < 2.00	Si : < 1.00	SiO2 : 10.00 – 15.00	Fe2O3 : 15.00 – 25.00
K2O : < 2.00				

MECHANICAL PROPERTIES (Typical values, all weld metal)

Yield Strength N/mm²	Tensile Strength N/mm²	Elongation 5d (%)	Impact Strength Charpy V notch (ISO-V)

GENERAL INFORMATION

Welding positions	NA			
Shielding gas	NA			
Packing	5 Kg in a plastic box			
Polarity	Ac or DC, straight polarity (electrode negative)			
Diameter (mm)	2.5	3.2	4.0	5.0
Length (mm)	350	350	450	450
Approx. current (A)	120 - 160	160 - 250	200 - 350	260 – 390

Tips & Tricks

Electrode position: 90° to work piece.
On thick pieces: make an up and down saw movement.