

Electrode for preheating metals**GENERAL DESCRIPTION**

The special coating of this electrode generates a concentrated heat input in the work piece without depositing any metals. There is only a little bit of slag that can easily be removed with a brush. Modi Lastek 1001 can be used for bending and straightening profiles and plates.

APPLICATIONS

Locally heating of art and ornamental work.
 Forging small pieces.
 Dismantling of the steering pivot pin of trucks.
 Removal of inner ring of a roller bearing jammed on a shaft. (use Modi Lastek 1000 to cut the outer ring)
 Preheating of a weld that must be peened.

Heat input per electrode:

For diam. 4.0mm (5/32") – approx. 680 kJ
 For diam. 3.2mm (1/8") – approx. 430 kJ

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

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)

GENERAL INFORMATION**Welding positions****Shielding gas****Packing**

Polarity Ac or DC, straight polarity (electrode negative)

Diameter (mm) 3.2 4.0

Length (mm)

Approx. current (A) 130 - 160 200 - 230

Tips & Tricks

Arc length: 15 to 20 mm (0.6 – 0.8 inch) from the work piece.
 Move the electrode over the work piece if a larger area has to be preheated
 To avoid even slight damage to the work piece, strike the arc on a piece of waste material.

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.