

Lastek 11017

High impact strength

CLASSIFICATION

EN ISO 2560-A : E 50 6 Mn 1Ni B 42 H5

AWS A5.5 : E 8018-G

GENERAL DESCRIPTION

Basic electrode for fine grained or Ni-alloyed steels with a high yield strength and impact value.

Easily removable slag.

Perfectly suitable for welding Corten steel

APPLICATIONS

Pressure vessels, bridges, machine constructions, shipbuilding, machine supports, tanks and pipes.

Constructions subjected to severe weather conditions.

Impact Strength Av (ISO V):

@ 20 °C > 135 J

@ 0 °C > 120 J

@ -20 °C > 100 J

@ -40 °C > 60 J

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

C : 0.06	Si : 0.50	Mn : 1.60	Ni : 0.90	P : < 0.02
S : < 0.02				

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)
≥ 510 MPa	590 - 690 MPa	≥ 23%	≥ 47 J (-60°C)

GENERAL INFORMATION

Welding positions All, except vertical down.

Shielding gas NA

Packing 5 kg in a plastic box

Polarity DC, reverse polarity (electrode positive)

Diameter (mm) 2.5 3.2 4.0

Length (mm) 350 450 450

Approx. current (A) 60 - 90 90 - 135 140 - 180

Tips & tricks

Maintain a short arc, the electrode almost in vertical position to the work piece.

Avoid porosities by striking the arc on a spare piece of metal. Renew this procedure for each weld. At the end of the bead come back with the arc on the deposit to avoid crater-formation.

Always use very dry electrodes to obtain the highest possible mechanical characteristics.

When necessary preheat and dry the electrodes in the Lastidry for 2 h at 300 °C (570 °F)

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.