

# Lastek 82

## Electrode with excellent weldability

### CLASSIFICATION

EN ISO 2560-A : E 42 0 RC 11

AWS A5.1 : E 6013

### GENERAL DESCRIPTION

Special steel electrode for badly prepared parts and wide open joints.

Very easy to use.

Smooth weld appearance in all positions.

Low open circuit voltage, making arc ignition very easy.

Can be used with all welding machines.

Can be used for tack welding.

The slag is self-releasing.

### APPLICATIONS

Construction of boilers and machines.

For universal use in badly prepared constructions.

Welding of low- and unalloyed cast steel.

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

<b>C :</b> 0.06 - 0.10	<b>Mn :</b> 0.40 - 0.70	<b>Si :</b> 0.35 - 0.70	<b>P :</b> < 0.02	<b>S :</b> < 0.02
<b>Fe :</b> Balance				

### MECHANICAL PROPERTIES (Typical values, all weld metal)

Yield Strength N/mm <sup>2</sup>	Tensile Strength N/mm <sup>2</sup>	Elongation 5d (%)	Impact Strength Charpy V notch (ISO-V)
≥ 400 MPa	490 - 550 MPa	≥ 24%	≥ 50 J (20°C)

### GENERAL INFORMATION

**Welding positions** All

**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

**Length (mm)** 350 350 350

**Approx. current (A)** 60 - 90 100 - 120 140 - 160

**Tips & tricks** For well-prepared joints: weld with short arc or in contact.  
For badly prepared joints: limit the size of the weldpool by interrupting the arc.

*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.*