

# Lastek 43

## Special electrode for ground layer on cast iron

### CLASSIFICATION

EN ISO 1071 : E C St 1

AWS A5.15 : E St-16

### GENERAL DESCRIPTION

Lastek 43 has been developed for the repair of "unweldable" cast iron, where Ni base electrodes do not give a solid bond. The special coating develops a powerful cleaning action. The aggressive arc penetrates through the oxidised or contaminated surface and provides a perfect bond.

Lastek 43 absorbs the carbon from the cast iron and the deposit becomes hard and nonmachinable.

Lastek 43 should be used as a buttering run in the groove made with Lastek 1900.

The beads should not touch. The joint is finished with electrodes such as Lastek 40E, 42E or 41E.

### APPLICATIONS

Welding all poor quality cast iron, reclamation on ship motor blocks, oxidised furnace parts, repairing foundry defects for colour match, first layer on cast iron prior to hardfacing (spreader cones in brick extrusion machinery, cast iron gears.)

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

<b>C :</b> 0.03	<b>Mn :</b> 0.15	<b>Si :</b> 0.10	<b>Fe :</b> 99.00	<b>P :</b> < 0.015
<b>S :</b> < 0.015				

### 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)
	≥ 390 MPa	≥ 30%	

### GENERAL INFORMATION

**Welding positions** All

**Shielding gas** NA

**Packing** 5 kg in a plastic box

**Polarity** AC or DC, reverse polarity (electrode positive)

**Diameter (mm)** 3.2 4.0

**Length (mm)** 350 350

**Approx. current (A)** 100 - 120 120 - 140

**Tips & tricks** Weld with a weaving motion in the direction of travel.  
During the forward motion the arc bites into the cast iron.  
During the backward motion Lastek 43 deposits a droplet on the previous deposit.

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.