

Lastek 8003 C

Welding dissimilar metals

CLASSIFICATION

EN ISO 14343-A : W 23 12 L Si
AWS A5.9 : ER 309LSi

GENERAL DESCRIPTION

TIG-rod for crack free joining of stainless steel to carbon steel, to low alloyed steel and cast steel.
Suitable for tough, crack arresting underlayers for hardfacings.

APPLICATIONS

Joining austenitic and ferritic stainless steel to low- and unalloyed steel (17Mn4, StE355, ...).

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

C : < 0.03	Si : 0.65 - 1.00	Mn : 1.00 - 2.50	Cr : 23.00 - 25.00	Ni : 12.00 - 14.00
Mo : < 0.75	Cu : < 0.75	P : < 0.03	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)
≥ 320 MPa	≥ 510 MPa	≥ 25%	≥ 47 J (20°C)

GENERAL INFORMATION

Welding positions NA

Shielding gas Argon (or Helium or Argon/H2 mixed gas)

Packing 5 kg in a cardboard box

Polarity DC, with the torch on the negative pole.

Diameter (mm)	1.6	2.0	2.4	3.2	4.0
Lenght (mm)	1000	1000	1000	1000	1000

Tips & tricks Avoid heat treatment at temperatures above 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.