PRODUCT SPECIFICATION

Lastek 803 C

Good intergranular corrosion resistance

CLASSIFICATION

EN ISO 14343-A : W 19 9 L Si
AWS A5.9 : ER 308LSi

GENERAL DESCRIPTION

Welding rod for TIG (or oxy-acetylene) welding of stabilized or low carbon austenitic stainless steel of the type 18/8. (AISI 304 - 304L - 321 - 347).
Good corrosion resistance up to 350 °C (660 °F).

APPLICATIONS

Stainless steel that has to be polished for decorative applications.
Tanks for milk and other food.
Construction welding in the chemical and food industry.
Household apparatus and industrial kitchen equipment.
Medical equipment.
Applications in pharmaceutical industries.
Heat exchangers, steam pipes, overheaters, etc....

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

C :	< 0.03	**Si :**	0.65 - 1.00	**Mn :**	1.00 - 2.50	**Cr :**	19.50 - 22.00	**Ni :**	9.00 - 11.00
Mo :	< 0.75	**Cu :**	< 0.75	**P :**	< 0.03	**S :**	< 0.02		

MECHANICAL PROPERTIES (Typical values, all weld metal)

Yield Strength N/mm²	Tensile Strength N/mm²	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					
Packing	5 kg in a cardboard box					
Polarity	DC, with the torch on the negative pole.					
Diameter (mm)	1.0	1.6	2.0	2.4	3.2	4.0
Lenght (mm)	1000	1000	1000	1000	1000	1000

Tips & tricks	Oxy-acetylene welding is possible with neutral flame or with a light acetylene excess. Apply flux Lastek 802CA on rod and work piece.