PRODUCT SPECIFICATION

Lastek 804 C

Excellent pitting corrosion resistance

CLASSIFICATION

EN ISO 14343-A : W 19 12 3 L Si
AWS A5.9 : ER 316LSi

GENERAL DESCRIPTION

Welding rod for TIG (or oxy-acetylene) welding of stabilized or low carbon austenitic stainless steel of the type 18/8Mo (AISI 316 - 316L and 316Ti - 318 at temperatures below 350°C).
Excellent pitting corrosion resistance.
Good corrosion resistance up to 350°C (660°F).

APPLICATIONS

Applications where chlorine ions can be expected in the chemical, petrochemical, pharmaceutical and food industry.
Construction welding in saltwater and marine environments.
Household apparatus, industrial kitchen equipment and medical apparatus, etc....

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

C :	< 0.03	**Mn :**	1.00 - 2.50	**Si :**	0.65 - 1.00	**Cr :**	18.00 - 20.00	**Ni :**	11.00 - 14.00
Mo :	2.00 - 3.00	**Cu :**	< 0.75	**S :**	< 0.03	**P :**	< 0.03		

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)	0.8 - 4.0
Lenght (mm)	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.