

# Lastek 121

## High efficiency electrode

### CLASSIFICATION

EN ISO 2560-A : E 42 A RR 73

AWS A5.1 : E 7024

### GENERAL DESCRIPTION

Electrode for fillet welding and butt welding of construction steel at high travel speed. Because the deposit is twice as fast as with multilayer techniques with conventional rutile electrodes, the shrinking force that could lead to twisting or distortion is minimized. Long beautiful welding beads; slag easy to remove.

Efficiency: 160 %.

### APPLICATIONS

Filling V-grooves and fillet welds.

Steel and cast steel with tensile strength up to 520 N/mm<sup>2</sup>.

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

<b>C :</b> 0.06 - 0.10	<b>Mn :</b> 0.60 - 0.80	<b>Si :</b> 0.40 - 0.60	<b>P :</b> < 0.025	<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)
≥ 420 MPa	≥ 520 MPa	≥ 23%	≥ 70 J (20°C)

### GENERAL INFORMATION

**Welding positions** PA, PB, PC

**Shielding gas** NA

**Packing** 5 kg in a cardboard box

**Polarity** AC or DC, straight polarity (electrode negative)

**Diameter (mm)** 3.2 4.0 5.0

**Length (mm)** 450 450 450

**Approx. current (A)** 120 - 180 180 - 220 260 - 320

**Tips & tricks** Weld with short or medium arc length.  
Can be welded with dragging or weaving technique.  
The electrode is kept slightly inclined in the direction of the weld.

*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.*