

Lastek 17

Welding galvanising baths in Armco-iron

CLASSIFICATION

EN ISO 2560-A : E 38 Z A 22

AWS A5.1 : E 6020

GENERAL DESCRIPTION

Weld deposit with extra low carbon and silicon content.
Welding of mild steel that has to be Zinc coated.
Smooth welding beads.

APPLICATIONS

Lastek 17 can be used to weld Armco iron, that is resistant to molten zinc at 475 °C (887 °F) due to its low carbon and silicon content.
Lastek 17 is also useful for welding mild steel that has to be galvanised. The zinc coating will be more uniform than with other filler metals.

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

C : 0.06	Mn : 0.34	Si : 0.09	P : < 0.02	S : < 0.02
Fe : Balance				

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)
	450 MPa	≥ 15%	

GENERAL INFORMATION

Welding positions All, except vertical down.

Shielding gas NA

Packing 5 kg in a plastic box

Polarity AC or DC, straight polarity (electrode negative)

Diameter (mm) 3.2 4.0

Length (mm) 350 350

Approx. current (A) 80 - 130 110 - 160

Tips & tricks Lastek 17 can be welded in contact with the work piece.
Use a high welding speed, the electrode inclined at an angle of 60-70°.
Open circuit voltage 70 V minimum on AC.

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.