

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/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

Packing 5 kg in a cardboard box

Polarity DC, with the torch on the negative pole.

Diameter (mm) 0.8 - 4.0

Length (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.

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.