

Lastek 807 C

Joining difficult to weld steel and buffer layers for hard facing

CLASSIFICATION

EN ISO 14343-A : W 18 8 Mn

AWS A5.9 : ER 307Si

GENERAL DESCRIPTION

TIG rod for joining steels with poor weldability.

Exceptional crack resistance also on self-hardening or manganese steels.

Work hardens up to 400 HB under impact load without the slightest cracks and can therefore be used as a hard facing against wear and impact.

Oxidation resistant up to 850°C (1560°F).

APPLICATIONS

Welding of high alloyed, wear-resistant chrome steels (s.a. 3CR12 and related) and steels with poor weldability.

Welding stainless steel to carbon steel.

Joining and cladding workpieces with a 14% manganese content.

Base layer for extra hard facings on moulds and tools.

Surfacing rails and cams.

Welding workpieces subjected to shocks, impact and metal to metal friction.

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

C : < 0.20	Si : < 1.50	Mn : 5.00 - 8.00	Cr : 17.00 - 20.00	Ni : 7.00 - 10.00
P : < 0.03	S : < 0.03	Mo : < 0.50	Cu : < 0.50	

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)
≥ 350 MPa	≥ 500 MPa	≥ 25%	≥ 50 J (R.T.)

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) 1.6 2.4 3.2

Length (mm) 1000 1000 1000

Tips & tricks

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.