

## CAST IRONS

### MMA ELECTRODES:

#### Lastek 40E

- > Pore free welding of dirty cast iron»

#### Lastek 41E

- > Joining cast iron to steel»

#### Lastek 43

- > Buttering layer on "bad quality" cast iron»

#### Lastek 42E

- > Crack free welding of thin walled cast iron»

#### Lastek 47E

- > Cast iron to steel»

### TIG RODS:

#### Lastek 415

- > TIG rod for welding cast iron»

#### Lastek 11

- > Structure- and colour match on cast iron»

### MIG WIRES:

#### Lastifil 41G

- > Flux cored wire for welding cast iron»

## STAINLESS STEELS

### MMA ELECTRODES:

#### Lastek 800

- > Resistant to intergranular corrosion»

#### Lastek 801

- > Resistant to intergranular - and pitting corrosion.»

#### Lastek 802

- > Heat and corrosion resistant»

#### Lastek 803

- > Welding 18/8 austenitic stainless steel with low carbon content»

#### Lastek 804

- > High corrosion resistance, easy to polish»

#### Lastek 803B

- > Electrode with very low carbon content for welding austenitic stain- less steel of the type 18/8»

#### Lastek 804B

- > Welding stainless steel 316L»

#### Lastek 805

- > Stainless steel electrode - vertical down»

#### Lastek 806

- > Resistant to sulphur containing vapour and heat»

#### Lastek 809

- > For welding dissimilar metals»

## Lastek 821

- > High erosion- and cavitation resistance»

## Lastek 8000

- > Joining carbon steel to stainless steel»

## Lastek 8003

- > Tack welding of thin steel sheets»

## Lastek 8009

- > Exceptional corrosion resistance in seawater»

## Lastek 8312

- > Welding of 3CR12 and Nirosta 4003»

## TIG RODS:

### Lastek 802C

- > Heat and corrosion resistant»

### Lastek 803C

- > Good intergranular corrosion resistance»

### Lastek 804C

- > Excellent pitting corrosion resistance»

### Lastek 810C

- > Corrosion resistant, machinable hardfacing»

### Lastek 813C

- > Machinable hardfacing layer for hot working dies»

### Lastek 852C

- > TIG rod for welding duplex stainless steel»

### Lastek 8003C

- > Welding dissimilar metals»

### Lastek 8009C

- > Welding stainless steel '904L'»

## MIG WIRES:

### Lastifil 802

- > Welding of heat resistant steel (AISI 310)»

### Lastifil 803

- > Solid welding wire for stainless steel 304L»

### Lastifil 803G

- > Cored wire for stainless steel 304L»

### Lastifil 804

- > Solid wire for stainless steel 316L»

### Lastifil 804G

- > Cored wire 316L»

### Lastifil 807

- > Joining difficult to weld steel - highest toughness»

### Lastifil 809G

- > Cored wire for crack-resistant joints»

### Lastifil 8003

- > Welding dissimilar metals»

### Lastifil 8009

- > Welding stainless steel '904L'»

## UNALLOYED STEELS

### **MMA ELECTRODES:**

#### **Lastek 001**

- > All positional»

#### **Lastek 002**

- > Long weld length»

#### **Lastek 003**

- > Upward welding in the vertical position»

#### **Lastek 004**

- > High travel speed»

#### **Lastek 005**

- > Universal construction electrode»

#### **Lastek 006**

- > High impact -value»

#### **Lastek 007**

- > Root passes»

#### **Lastek 008**

- > High strength»

#### **Lastek 009**

- > Special pipe welding electrode»

#### **Lastek 17**

- > Welding galvanising baths in armco-iron»

#### **Lastek 20**

- > Exceptional weldability»

#### **Lastek 82**

- > Universal use»

#### **Lastek 88**

- > Welding thin steel sheets»

#### **Lastek 121**

- > High efficiency electrode»

#### **Lastek 126**

- > Basic coated - high recovery»

#### **Lastek 1120**

- > Root runs with radiographic quality»

#### **Lastek 1130**

- > Basic electrode for high mechanical characteristics»

### **TIG RODS:**

#### **Lastek 170**

- > Oxy-acetylene welding rod for mild steel»

#### **Lastek 171**

- > Root pass in steel pipes»

### **MIG WIRES**

#### **Lastifil 20**

- > Solid welding wire - Steel»

#### **Lastifil 20GA**

- > Solid wire for welding galvanized steel»

## Lastifil 20TB

- > Basic flux cored wire»

## Lastifil 20TM

- > Cored wire for high quality steel welding. (Ar-CO<sub>2</sub>).»

## Lastifil 20TR

- > Rutile flux cored wire»

## LOW ALLOY STEELS

### MMA ELECTRODES:

#### Lastek 1216

- > For creep resistant steel 1Cr-0.5Mo»

#### Lastek 1222

- > Creepresistant steels 2Cr - 1Mo»

#### Lastek 10015

- > Welding low alloy high strength steels»

#### Lastek 11016

- > High impact strength»

### TIG RODS:

#### Lastek 151

- > Mild and creep resistant steel»

#### Lastek 10015C

- > High tensile strength»

### MIG WIRES:

#### Lastifil 1216

- > Welding creep resistant steel»

#### Lastifil 10015

- > Welding low alloy high strength steels»

#### Lastifil 11017

- > Welding weathering steels»

## DIFFICULT TO WELD STEELS

### MMA ELECTRODES:

#### Lastek 85

- > Joining dissimilar metals and difficult to weld steels»

#### Lastek 90

- > High strength - soft arc»

#### Lastek 95

- > Welding very massive workpieces»

#### Lastek 807

- > Buffer layers on problem steel»

#### Lastek 809

- > For welding dissimilar metals»

#### Lastek 8000

- > Joining carbon steel to stainless steel»

## Lastek 9066

- > Electrode for joining dissimilar metals with highest crack resistance»

## TIG RODS:

### Lastek 85C

- > Crack-free welds on problem steels»

### Lastek 982

- > TIG rod for joining nickel alloys and dissimilar metals»

### Lastek 8003C

- > Welding dissimilar metals»

## MIG WIRES:

### Lastifil 85

- > Joining difficult to weld steel - highest strength»

### Lastifil 807

- > Joining difficult to weld steel - highest toughness»

### Lastifil 982

- > For inconel and nickel alloys»

### Lastifil 8003

- > Welding dissimilar metals»

### Lastifil 8070

- > Flux-cored wire for joining dissimilar metals»

### Lastifil 8071

- > Flux cored hardfacing wire - heavy impact resistance Joining problem steels»

### Lastifil 809G

- > Cored wire for crack-resistant joints»

## HARDFACING

## MMA ELECTRODES:

### Lastek 22

- > Heavy impact»

### Lastek 24

- > Earthmoving equipment»

### Lastek 25

- > Machinable surfacing»

### Lastek 26

- > High hot- hardness»

### Lastek 27

- > Multilayer hardfacing»

### Lastek 98

- > Ni based hardfacing electrode for hot work stamping dies»

### Lastek 210E

- > Extremely wear- and abrasion- resistant deposit.»

### Lastek 211

- > Very thin tungsten carbide deposits»

### Lastek 230

- > Hot working dies»

### Lastek 231

- > Cutting of steel»

## Lastek 234

- > Cold working dies»

## Lastek 251E

- > Wear at elevated temperatures»

## Lastek 256E

- > Corrosion and wear at elevated temperatures»

## Lastek 261E

- > Resistant to shocks and very high temperatures»

## Lastek 262E

- > Rubber, paper and plastic»

## Lastek 265E

- > Impact loading at elevated temperatures»

## Lastek 272

- > Machinable refacing»

## Lastek 2027

- > High efficiency hardfacing electrode»

## Lastek 2400

- > Abrasion and impact»

## TIG RODS:

### Lastek 210A

- > Tube rod with tungsten carbides»

### Lastek 231C

- > Sharp cutting edges»

### Lastek 236C

- > Plastic moulds»

### Lastek 250C

- > TIG welding rod for machinable and compression resistant hardfacing.»

### Lastek 251A

- > Abrasion and corrosion»

### Lastek 256A

- > Valves and valve seats»

### Lastek 262A

- > Wood cutting tools»

### Lastek 909C

- > High degree of polishing in abrasive media»

### Lastek 2009

- > Very hard wear facing layers with oxy/ac torch»

### Lastek 2300C

- > Hot working dies and tools»

### Lasticut

- > Very rough surface»

## MIG WIRES:

### Lastifil 231

- > High hardness, excellent shock resistance»

### Lastifil 236TM

- > Metal powder cored wire - 600 Brinell»

### Lastifil 238GM

- > Metal powder cored wire - 62/66 Rc - open arc»

## Lastifil 239GM

- > Metal powder cored wire - 600 Brinell - open arc»

## Lastifil 250

- > Machinable hard facings»

## Lastifil 251G

- > Cored wire on cobalt base - very hard»

## Lastifil 256G

- > Flux cored wire on Cobalt base»

## Lastifil 350

- > Hardfacing wire 350 Brinell»

## Lastifil 350G

- > Self-shielded flux cored hard surfacing wire - 350HB»

## Lastifil 600

- > Hard and impact resistant wear facing wire»

## Lastifil 811

- > Surfacing of rolling mills»

## Lastifil 812

- > Hardfacing of moulds for tiles»

## Lastifil 2017G

- > High abrasion and impact resistance»

## Lastifil 2400G

- > Flux cored wire with outstanding abrasion resistance»

## Lastifil 2461GM

- > Metal powder cored wire 65-68Rc»

## ALUMINIUM & ALUMINIUM ALLOYS

### MMA ELECTRODES:

#### Lastek 62

- > Welding of aluminium castings»

#### Lastek 7002

- > Electrode for welding aluminium profiles and plates»

### TIG RODS:

#### Lastek 15

- > Welding of titanium»

#### Lastek 71

- > Brazing aluminium and its alloys»

#### Lastek 73

- > Pure aluminium»

#### Lastek 74

- > Welding Aluminium with 3%Mg»

#### Lastek 75

- > Welding magnesium»

#### Lastek 77

- > Welding AlMg5 - highest strength»

#### Lastek 78

- > Braze welding Aluminium»

#### Lastek 712

- > Welding of AlSi7Mg castings»

**MIG WIRES:**

**Lastifil 71**

- > Aluminium-silicon MIG welding wire»

**Lastifil 77**

- > Welding AlMg 5»

**Lastifil 79**

- > Welding pure aluminium»

**Lastifil 780**

- > Solid welding wire for hardenable aluminium plates and profiles»

## NICKEL & ALLOYS

**MMA ELECTRODES**

**Lastek 9065**

- > Welding electrode for welding of nickel alloys and for welding dissimilar metals»

**Lastek 9066**

- > Electrode for joining dissimilar metals with highest crack resistance»

**Lastek 9067**

- > Excellent corrosion and high temperature properties.»

**TIG RODS:**

**Lastek 918**

- > Hardens when temperature rises»

**Lastek 925**

- > Nickel based rod with excellent corrosion resistance»

**Lastek 967**

- > Welding of monel®400»

**Lastek 979**

- > Outstanding corrosion resistance»

**Lastek 982**

- > TIG rod for joining nickel alloys and dissimilar metals»

**MIG WIRES:**

**Lastifil**

**925**

- > Welding of Inconel®625»

**Lastifil 982**

- > For inconel and nickel alloys»

## COPPER & ALLOYS

**MMA ELECTRODES:**

**Lastek 61G**

- > Smooth bronze layers on low current»

**Lastek 63**

- > Pure copper»



## Lastek 64

- > Aluminium bronze electrode»

## TIG RODS:

### Lastek 12

- > Brazing rod for steel, maximum strength»

### Lastek 52V

- > Steel sheet metal and cast brass parts»

### Lastek 53

- > Welding pure copper»

### Lastek 55

- > Steel furniture, high tensile strength»

### Lastek 56

- > Flux cored brazing rod»

### Lastek 57

- > Oxy acetylene brazing of rusted steel sheets»

### Lastek 58

- > Surfacing cast iron with bronze»

### Lastek 64C

- > TIG welding aluminium-bronze»

### Lastek 503

- > Seawater resistant»

### Lastek 508

- > TIG welding of brass and bronze»

### Lastek 512

- > Bronze welding»

## MIG WIRES:

### Lastifil 61

- > Welding pure copper»

### Lastifil 64

- > Seawater resistant bronze wire»

### Lastifil 508

- > Hard phosphor bronze refacings»

### Lastifil 5003

- > Easy flowing copper alloy for MIG welding»

## SPECIAL MMA ELECTRODES

### Lastek 1000

- > Cutting stainless steel and cast iron»

### Lastek 1001

- > Electrode for preheating metals»

### Lastek 1010

- > Spot welding of metal»

### Lastek 1900

- > Gouging and grooving»

## SILVER SOLDER

### BLANK:

#### Lastek 31

- > Capillary brazing at lowest temperature»

#### Lastek 32

- > Silver solder for larger gaps»

#### Lastek 33

- > Brazing alloy with high fluidity»

#### Lastek 34

- > Silver solder with good fluidity»

#### Lastek 38

- > Silver solder for copper alloys»

#### Lastek 38B

- > Very thin flowing silver alloy»

#### Lastek 39

- > No flux on pure copper»

#### Lastek 330

- > Brazing of stainless steel»

#### Lastek 332

- > Silver brazing alloy for general maintenance work»

#### Lastek 391

- > Brazing copper tubes»

### COATED:

#### Lastek 31V

- > Capillary brazing at lowest temperature»

#### Lastek 32V

- > Silver solder for larger gaps»

#### Lastek 33V

- > Brazing alloy with high fluidity»

#### Lastek 34V

- > Silver solder with good fluidity»

#### Lastek 330V

- > Brazing of stainless steel»

#### Lastek 332V

- > Silver brazing alloy for general maintenance work»

### PASTE:

#### Lastek 30PA

- > Silver brazing paste»

## SOFT SOLDER

### SOLDER:

#### Lastek 3102

- > Soft solder for stainless steel»

#### Lastek 3102IS

- > Flux cored soft solder for stainless steel»

## Lastek 3204IS

- > Flux cored soft solder for general use»

## Lastek 3250S

- > Soft solder for all metals»

## Lastek 3414

- > Soldering aluminium without use of a flux»

## Lastek 3476IS

- > Soft solder for aluminium»

## Lastek 3413

- > Repair of cast zinc-aluminium pieces»

## PASTE:

### Lastek 300P

- > Tinning»

### Lastek 3102PA

- > Soldering paste for stainless steel»

## HARDFACING POWERS

## HOT:

### P902

- > Machinable spraying powder with excellent bond strength on chromium steel.»

### P903

- > Copper containing spraying powder»

### P905

- > Corrosion resistant spraying powder»

### P906

- > Metal spray powder containing tungsten carbides»

### P907

- > Machinable spraying powder for metal to metal wear»

### P909

- > Spraying powder for very hard, smooth and dense coatings»

### P910

- > Spraying powder with tungsten carbides»

### P912

- > Cobalt based spraying powder - 49 Rc»

### P956

- > Cobalt based spraying powder - 42 Rc»

### P9026

- > Moulds and bottom plates in the glass industry»

## COLD:

### P921

- > Exothermic spraying powder to be used as bond coat»

### P922

- > Cold spraying' bronze powder»

### P923

- > Cold spraying' powder for metal to metal wear»

**P927**

- > Replacement for chrome plating on plungers»

## **FLUXES & CHEMICALS**

### **TYPES:**

#### **Lastacid**

- > Removal of flux residues»

#### **Lastalu-AR**

- > Pickling agent for aluminium»

#### **Lasticool**

- > Heat-absorbing paste»

#### **Lastinox TS**

- > Pickling and passivating»

#### **Lastonox SP-K**

- > Pickling agent for stainless steel surfaces»