

**Joining of - and buffer layers on problem steels****CLASSIFICATION**

EN ISO 14700 (E Fe10)  
A5.4 (E 307-26)

**GENERAL DESCRIPTION**

Lastek 807 is a high strength, ductile, crack resistant electrode designed for welding problem steels such as high carbon and crack sensitive tool steels or manganese steel.

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

Rust proof.

Recommended for hardfacings; High resistance to wear and heavy shocks.

Excellent weldability in all positions, except vertical down.

High recovery (160 %).

**TYPICAL USE**

Joining of highly alloyed and difficult to weld steel.

Surfacing and repair of excavators buckets.

Joining and surfacing of rails and steel with 14 % manganese.

Cushion layer for hard facings.

Surfacing of rollers, crane-wheels, ...

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

C	Si	Mn	Cr	Ni	P	S
< 0.10	1.0 - 2.0	4.0 - 6.0	18.0 - 20.0	9.0 - 10.5	< 0.025	< 0.025

**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)
> 450 MPa	> 610 MPa	≥ 40%	

**General information**

**Welding positions:** All, except vertical down.

**Shielding gas:** NA

**Dia (x length) (mm):** 2.5 - 4.0 (x 350) / 5.0 (x 450)

**Packing:** 5 kg in plastic box

**Polarity:** AC or DC, reverse polarity (electrode positive)

**Tips & tricks:** Keep the arc as short as possible. Electrode position almost 90° to the workpiece.  
For welding 14% Mn-steel, keep the temperature of the workpiece below 350 °C (660 °F)

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.