

Very hard wear – resistant layers with oxy/ac torch**GENERAL DESCRIPTION**

Coated composite rod for applying wear resistant layers with extreme resistance against abrasion. Because of the particular composition of the coating, the deposit is also corrosion resistant. Fast deposition thanks to the self-fluxing character of the coating. Modi Lastek 2009 can be applied in several layers and has a smooth surface. It is not machinable. Appropriate for hard facing steel, cast steel, stainless steel and cast iron.

APPLICATIONS

Missing blades and scrapers, transport- and mixing augers, for the brick and ceramics industry, and for the processing of moulding sand foundries. Scrapers, mixers and transport augers in installations for water purifications. Mixing-, transport- and decanting screws of scraper blades in the food industry and cement industry. Blowers, pump rotors transporting abrasive liquids or mud, dredging teeth, drilling tools, etc...

Hardness of the matrix (Modi Lastek gr6): ± 45 HRC
Hardness of the hard components (Modi Lastek gr6): >3000 HV

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

Ni : 30.00 – 40.00	WC : 60.00 – 70.00			
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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)

GENERAL INFORMATION**Welding positions****Shielding gas****Packing****Polarity**

Diameter (mm)	5.0	6.0	8.0
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Length (mm)**Approx. current (A)****Tips & Tricks**

Modi Lastek 2009 is intended to be used with the oxy-acetylene torch. It can also be applied with a TIG-torch. Use a soft, slightly reducing oxy-acetylene flame. Burner tip one size bigger than usual for steel with the same thickness. Cleaning the surface: remove rust, dirt, grease and other impurities. Avoid overheating and stirring the molten pool. For hard facing large areas and also for surfacing cast iron, it is recommended to protect the surface with a thin layer of P902 or P907 (Lastispray) before starting the hard facing process with Modi Lastek 2009.

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.