

Extremely wear- and abrasion- resistant deposit.**GENERAL DESCRIPTION**

The deposit of Modi Lastek 210E is a slag free, hard alloy matrix with tungsten carbide particles throughout. High resistance to abrasion by minerals, ore, cement, etc. The deposit is not machinable neither easily ground.

APPLICATIONS

Brick kilns, concrete and cement works, stone quarries, gravel pits. Typical parts include mixing blades, augers, scraper blades, walls of dredging buckets, hammer-mills, pulverisers, plough shares etc...

Hardness matrix: 70 HRC
Hardness carbides: 1800 - 2200 HV

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

WC : 60.00	Fe : Balance			
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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	PA, PB, PC	
Shielding gas	NA	
Packing	5 Kg in a plastic box	
Polarity	AC or DC, Reverse polarity (electrode positive)	
Diameter (mm)	3.2	4.0
Length (mm)	350	350
Approx. current (A)	85	105

Tips & Tricks

Clean the work pieces. Keep a short arc. Use an amperage as low as possible.
For thick layers to be built up: apply a buffer layer with Modi Lastek 27, and a final layer with Modi Lastek 210E.
For steel types subject to cracking: apply a buffer layer of Modi Lastek 8000 or Modi Lastek 807.

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.