

**Severe abrasion****GENERAL DESCRIPTION**

High chromium - iron alloyed electrode for applications subject to severe abrasion as by sand, cement, mud and others ...  
 Good bond on steel, cast steel, manganese steel.  
 Smooth deposit with very low friction coefficient. Long beads.

**APPLICATIONS**

Dredger teeth, grab jaws, stirring tools, mixers, wear plates, dredge pump parts, centrifugal pumps, augers, tillage tools.

Hardness: 57-62 HRC

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

C : 3.00 - 4.00	Cr : 27.00 - 32.00	P : < 0.025	S : < 0.025	Fe : Balance
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**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)

**GENERAL INFORMATION**

<b>Welding positions</b>	PA, PB, PC			
<b>Shielding gas</b>	NA			
<b>Packing</b>	5 Kg in a plastic box			
<b>Polarity</b>	AC or DC, Reverse polarity (electrode positive)			
<b>Diameter (mm)</b>	2.5	3.2	4.0	5.0
<b>Length (mm)</b>	350	350	350	450
<b>Approx. current (A)</b>	60-90	120-140	140-170	150-200

**Tips & Tricks**

Electrode position: almost 90° to work piece.  
 Weld with a short arc and at lowest possible amperage to avoid dilution with the base material. To obtain a crack-free coating: pre-heat material according to the instructions of the supplier. For thick layers: Use Lastek 27 as base layer.

*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.*