

Abrasion and impact

GENERAL DESCRIPTION

Hard facing electrode with first layer hardness up to 68 HRC on mild steel, depending on the parent metal. The wear facing shows little or no transverse cracking.

Good shock-resistance.

Smooth arc.

Easy to strike.

High hardness at elevated temperatures (up to 600 °C (1100 °F)) - (38-40 HRC)

APPLICATIONS

Recommended for severe wear accompanied by moderate to high impact.

Bone crushers, dredging teeth, feed screws in cement factories (fueller pumps) cement mixers, pulping knives etc.

Hardness: 60-68 HRC

Efficiency 195 %

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

C : < 5.00	Cr : 20.00 – 25.00	V : 9.00 – 12.00	Mn : 0.50 - 2.00	Si : < 2.00
P : < 0.03	S : < 0.03	Fe : Balance		

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)
NPD	NPD	NPD	NPD

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)	2.0	3.2	4.0
Length (mm)	350	350	450
Approx. current (A)	60 - 80	80 - 130	130 - 170

Tips & Tricks

Remove fatigued or cracked metal with Lastek 1900 or Lastek 1000.

For surfacing more than two layers use Lastek 27 as a base layer and Lastek 2400 to finish.

The electrode must be kept vertical to the work piece in order to obtain the maximum hardness.

Keep amperage as low as possible to avoid dilution with the base metal.