PRODUCT SPECIFICATION

Modi Lastek 25

Machinable surfacing

GENERAL DESCRIPTION

Good resistance to impact and wear.
Recommended for hard facing of wear parts that have to be machined afterwards.
Can be used as a base layer for extra hard wear facing layers.
Can be welded on A.C. despite the lime (basic) type coating.

APPLICATIONS

Toothed wheels, rollers and sprocket wheels of bulldozers, roller bridges, winch drums, rails, cams, clutches, ...
Base layer for hard facings.

Hardness: 270 - 340 HB

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

C : 0.10	Cr : 3.50	Mn : 0.40	Si : 0.50	Fe : Balance

MECHANICAL PROPERTIES (Typical values, all weld metal)

Yield Strength N/mm²	Tensile Strength N/mm²	Elongation 5d (%)	Impact Strength Charpy V notch (ISO-V)

GENERAL INFORMATION

Welding positions	All			
Shielding gas	NA			
Packing	5 Kg in a plastic box			
Polarity	AC or DC, Reverse polarity (electrode positive)			
Diameter (mm)	2.5	3.2	4.0	5.0
Length (mm)	350	450	450	450
Approx. current (A)	65-85	100-130	120-180	170-240
Tips & Tricks	Weld with a short arc and low current to limit the dilution with the base material. To obtain the maximum hardness, at least three layers are necessary.			