

Resistant to shocks and very high temperatures**GENERAL DESCRIPTION**

Wearfacing electrode on cobalt base with excellent corrosion resistance.
 Withstands oxidising and reducing atmospheres up to temperatures of 1150 °C (2100 °F).
 Very good resistance to fluctuating temperatures and to impact loading.
 Resists corrosion by organic products containing sulphur, even at high temperatures.
 Machinable with hard metal tools. Gives crack-free deposits also on large areas.
 Indicated as base layer for harder cobalt alloys such as Modi Lastek 251E, Modi Lastek 262E.
 Smooth and pore-free welding beads.

APPLICATIONS

Valve and valve seats of combustion engines, gas turbine blades, hot working cutting tools, glass cutting tools, blades of metal shears, pump shafts and bearings.

Hardness: 30-35 HRC.

Hardness after work hardening: approx. 40 HRC.

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

C : < 0.50	Cr : 26.00 – 29.00	Mo : 5.00 – 6.00	Mn : < 0.60	Si : < 2.00
Fe : < 3.00	Ni : 2.00 – 2.60	P : < 0.025	S : < 0.025	Co : 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)

GENERAL INFORMATION

Welding positions	All, except vertical down.	
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)	80 - 95	100 -130

Tips & Tricks
 Remove all rust and dirt.
 Sharp edges must be rounded for optimum adhesion.
 The arc should be short to avoid too much dilution with the base metal.

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.