PRODUCT SPECIFICATION

Modi Lastek 262 E

Rubber, paper and plastics

GENERAL DESCRIPTION

Cobalt base electrode for friction and corrosion resistant hardfacings.
Excellent resistance to high temperatures (up to 1000 °C) (1830 °F).
Machinable with hard metal tools.
Good shock resistance.
Resistance to nitric and acetic acid, superheated steam, flue gases, petroleum and plastics.

APPLICATIONS

Machine-parts for the manufacturing process of paper and plastics and wood.
Axles and bearings of centrifugal pumps, dies.

Hardness: 47 - 53 HRC.
Hot hardness: approx. 34 HRC @ 600 °C (1110 °F).

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

C : 1.50 – 1.90	Cr : 27.00 – 32.00	Fe : < 3.00	Mn : < 1.00	Mo : < 1.00
Ni : < 3.00	Si : < 2.00	W : 7.50 – 10.00	Co : 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	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)	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.
On crack sensitive steels, apply a base layer with Modi Lastek 9066.